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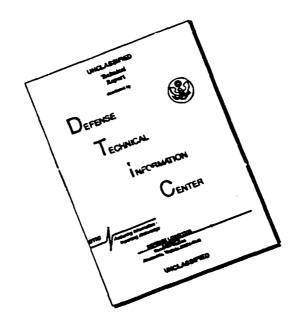
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TECHNOLOGY INSERTION-ENGINEERING SERVICES PROCESS CHARACTERIZATION TASK ORDER NO. 1

BOOK 2 OF 3

DATABASE DOCUMENTATION BOOK

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(WHEELS - WCD'S)

CONTRACT SUMMARY REPORT 15 DECEMBER 1989

CONTRACT NO. F33600-88-D-0567 CDRL SEQUENCE NO. B008



MCDONNELL DOUGLAS

McDonnell Douglas Missile Systems Company St. Louis, Missouri 63166-0516 (314) 232-0232

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## WHEEL BRAKET

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2-13102N DELETED

3-13103N DELETED

4-13104N DELETED

5-13105N NOSE 155Y

8-13151N NOSE OUTBOARD AF

9-13152N NOSE INBOARD

#### BRAKES

1-13201N BRAKE ASS'Y SLAP
2-13202N TORQUE FORE SAP
3-13203N LARRIER & LIVING: ORP
4-13204N PRESSURE FLATE SAP
5-13205 N Eroke Assy
6-13206 N TORQUE PLATE ASSY SAP
7 13207N DISK IND LINING ASSY

## WHEZZA/BRAKES'

1-38101N MLC TNECARD 201 2-38102N MLG ASSY 201 3-38107N MLG OUTBOARD SHE 4-38150N NLC TUBOARD SOP 5-38151N NLC OUTBOARD TOP 6-38152N NLG ASSY ZRE

## JBRAKES'

1-38201N BRAKE ZRP
2-38202N TOROUG TUBE JRP
3-38203N ROTATING DISK ZRP
4-38204N STATIONARY DISK ZRP
5-38205N BACKING PLATE ZRP
6-38207N PRESSURE PLATE JRP
7-38206N BRAKEASSY ZRP

#### BRAKET

1-1220IN BRAKE HOUSING SEP

2-12202N NOT FOUND. DELETED

3-12203N TORQUE TUBE SEP

4-12204N BACKING PLATE SEP

5-12205N PRESSURE PLATE SEP

6-12206N STATOR

7 12207N Brake ASSY

## 8.52 WHEELS



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17 - 16216H Compressor
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19- 11-219N 100kg 2000 ZRP
19- 16219N 150k2 ASEY ZRP
19. 16219N 100k2 Aser 2RP

## C.SA . B WHEELS

1- 21/01N MLC WHELASSY =RP 284	3-21159N NWheel mise:
2- 21103N MIG INBOARD ERP 141	4-21160N M wheel misc 5
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11-21157N Nichel 5-2 200	
12-21158N N Wheel 3:11 2pp	
C5A +B BRAKES	
2120/N BECKING PLATE	SPP
1-21202N STATOR, CARRIER CS	SPP
2-21203N ROTOR / CARRIER CS	SAP
3-21204N END PLATE / CARRIER C-5	LOP
4-21205N DELETE	
5- ZIZOGN HOUSING PISTON ASSY	
6-ZIZOTN TORQUE TUBE	220
7-21208N Brake Assy Barrie	
e 21209N PRESSURE PLATE ASSY	
9 21210N Brake Torque Tube ASS	
10 21211N Tube Torque	
11-21212N Torque Tube ASSX 2FA	
2-21213N DISK ROTOR ASSYDAP	
B-21 214N DISK - STRATOR SAP	• • • • • • • • • • • • • • • • • • •
4- 21215N SPICER PLITE JAN	
15-21216N BRAKE ASSYZER	
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C-7A	WHEELS
	and the contract of the contra

/-	20102N	WHEEL	INBOAR	D JRP
2-	20103 N	WHEEL	OUT BOAR	U SOP
3-	20104N	WHEEL	ASSY	20P

BRAKES

1- 2020/N DELETED/NO ON

C-130 WHEETS

1 8104N MAG WHEEL ASSY (DELETED) -18106N MIG WHEER INBOARD JIP لنبث - 18108N MLG WHEEL ASSY 1-18108N MLG WHEEZ OUTBOARD 25 -- 18111N MLC WHERE AS'SY TRP - 18112N MLG WHEEL INBOARD SHAP - 18 113N WHEEL OUTBOARD FRP MLC 3-18150N NLG WHEEL AXXY ZRP 7-1815IN NLG WHEEL ASSY (NAVY TO RESTURD DELETED) WHEEL OUTBOARD IRP 0-18/5ZN NLG 27/8/53N NAG WHEEL INBOARD ZRA 378154N NLG WHEEL INBOJK (NAVY) SOO WHEEL BUTBOARD (NAUY) ZEP 18/55N NLG

5-18156N NLG

WHEEL ASSY (NAUY) ZOP

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#### VC-130 BRAKEX

TORQUE TUBE TOP -18202N PRESTURE PLATE SAR 3-18203N BRAKE 130 SAP +-18204N BRAKE ASSY 2009 5-18205N - 18206N BRAKE DELETED 7- 18207N BRAKE ASSY DELETED 3-18208N HOUSING DELETED 7-18209N ROTATING DISK DAP 0-18210N ROTOR 2RP 1- IBZIIN BACKING PLATE DES 7: 18212N STATOR SAP 14-18214N Brake ASSY 200 14-18214N Brake ASSY 200 70 L MANUEL JAP 15 18213N PLATE SUBASSEMBLY SRA 15-18215N Brake assy 16: 18216N Housing they so

WHEELS/ BRAKES
C-141
1-19102N M/W OUT BOARD = EP
2-19 103N M/W OUTBURD TOP
3-19104N M/W INBOARD 200
4-19105N M/W AXXY
5-19106N M/W CAP
6-19107N M/W 1554 ERP
7-19108N m/w OUTBOARD ASSY JEP
P II
1-1920IN PLATE BACKING W
2-19202N BRAKE ASSY W
3-19203N TORQUE TUBE W
4-19204N ROTATING DISK W
5-19205N PRESSURE PLATE-W
J 11-50-17-CC 3 SWEB_17-ON-
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## WHEET PERNET

1- 39101N WHEEL ASSY ZEP
2-39102N W/H INBOARD ZEP
3-39103W W/H OUT BOARD ZEP
4-39160N NOSE W/H ASSY ZEP
5-39151N NOSE W/H INBOARD ZEP
6-39152N NOSE W/H OUTBOARD ZEP

#### BRAKEX

1-39201N BRAKE AFFY W

2-39202N ROTATING DISK W

3-39203N PRESSURE PLATE W

4-39204N STATIONARY DISK W

5-39205N BACKING PLATE W

6-39206N TORQUE Tube

7-39207N DELETED.

8-39208N BRAKE RSSY W

WHERE'S BRAKES

1-01101N WH DEMOUNTABLE, MEST 2-0110ZN W/IT FLANGE, M SOF 3- 01103W WHEEZ, M 4-01104N WHEEL FLANCE, M 5- 01105N SLEEVE BERRENS, M JE 6- 01106 N RINC EXCITER, M NOR 7-01107N W/H AFSY, M CAR 8- 01108N NOSE WHEEL, M 9- OIISON W/H OUTBOARD, N SAP 10- O 115IN W/H OUT BOARD, N DRS - 01152N RING, BETRING ADT., M JOS 12-01153N W/H MBOTED, N JAP 13-01154N WHEEL AFFY, N SAP 14-01155N WH INBOARD, N SAF. 15-01/56N WHEEZ ASSY, N 200

1-01202N BRAKE HOUSING FAC DAP

WHEELS / PLAKET PWING

F-5

WH

1-3410IN FLANGE, M/W =RR

2-3410ZN WHEEL ASSY, M = DRR

3-34103N WHEEL ASSY, M = DRR

4-34104N WHEEL DEMOUNTABLE, M-DRR

5-34105N WHEEL ASSY, M = CR

6-34106N WHEEL MASSY, M = CR

8-34106N WHEEL MASSY, M = DRR

8-34106N WHEEL OUT BOARD = DRP

9-34106N WHEEL IN BOARD = DRP

BRAKES 1-34201N PLATE SUB. ASSY PWR SON 14-34214N- Brake AS. 2-34202W ROTATING DISK ZOO 3-34203N STATIONARY DISK ZAP 4-34 ZOUN BRANE AFFY HOUSING ASSYDAP 5-34205N DISK SECONDARY JOBP 6-34206N TORQUE TURE CAP 7-34207N TORQUE TUBE OR 8-34209N PRESSURE PLATE 11 9-34210N BACKING PLATE 22P 10-34208N ROTETING DISK DEF 1-342117 STaTOR 200 12 34212N Brake ASSY ZRP DISK MSSY 13- 34213N

## WINDERS BRAKES ____

1-36101N WHEEL INBOARD, M2-36104N WHEEL ASSY YD SOP

4-36105N WHEEL OUTBOARD, M SPR

5-36106N WHEEL FLANGE
6-36107N ROTOR DRIVE KEYS COP

7-361081 WHEEL ASSY, M
8-36150N WHEEL HALF OUT BOARD SUP

9-36152N WHEEL HALF OUT BOARD SUP

10-36153N WHEEL ASSY SUB

#### BRAKES

1-36203N BRAKE ASSY AB ZOB

2-36204N HOUSTNG A/B SOB

3-36205N BACKING PLATE

4-36206N BRAKE HOUSTNC C/D

5-36207N TUBE, TOR QUE 2/O

6-36208N BOLTS SOB

36209N TORQUE TUBE A/B SOP

8-36210N DELETED

9-36212N BOLT

ROTATING DISK A/B STATIONARY DISK A/B 11-36214N 12-36215N ROTATING DISK A/B DAP Brake END PLATE A/B JOB 13-34216N PRESSURE PLATE A/B SOR 14-36217N STATIONARY DISX A/B SPP 15-36Z18N BACKING PLATE C/O 16-36 Z19 N STATIONARY DIFK C/D 17-342202 ROTATING DISK C/D 18-36221N PRESSURE PLATE C/D 19-36222N 20-36223N BRAKE HEAT STACK UD 21 36224N Heat Shield, Housing IDP ₩36225N END PLITE 23 36226N Pressure PLITE DISK SubJSSY, STATOR 34 36227N 25 36228N Heat Stack Assy 26 36229 N Brake ASSY END PLATE 2736230N 2836231N Pressure Plate Assy 2934232N DISK Subassy STITOR 30 34233N ROTOR SUB ASSY Hest stack Assy Brake ASSY \$31-36234M 30 ZING DON 1100 Heat Stack ASSY 33.36236N

## WHEELS BRAKES

1-37101N WHEEL INBOARD, M 140 2-37102N WHEEL FLANGE, M 28 3-37103N WHEEL ASSY, M 34

VF-14 BRAKES

1-37201N STATE #557 + HOUSING SEP

2-37202N TORQUE TUBE SEP

3-37203N BACKING PLATE SEP

4-37204N ROTATENG DISK SEP

5-37205N PRESSURE PLATE SEP

4-37204N STATIONARY DISK SEP

1-37207N SNO PLATE SEP

8-37207N SNO PLATE SEP

8-37208N Heat Stack ASSY SEP

10-37209N Brike ASSY SEP

END PLITE SEP

11- 37 alin

## F-16 Brakes

		, / 6	~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~	,	-
12-372	IDN STATION	ary Disk	SOF		
13- 3721	13N Pressu	re Plate	ZRP		
14-3721	14N ROTATI	ing DISK.	ser		<u></u>
15-3721	5N Heat s	Tack Assy	JAP		
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WHEELS BRAKES

1-02100N INBOARD WH HALF TOP

2-02101N OUTBOARD WH ARF SOP

3-02103N INBOARD WH JEE

4-02104N M/W ASSEMBLY TAP

5-02105N M/W ASSEMBLY TAP

6-02105N M/W OUTBOARD 2AP

7 04:04N M/W F-100/F-106 ASSY 2DP

8 04103N I.B. F-100/F-106 228

9 04101NOB F-100/ F-106 208

BRAKES

1-02201N Brake 18554 2-02202N HUB ASSY

3-02203N Ring

4 02204 NO ROTATING DISK

VF-106

1-07201N w PLate STATOR 2-07202N 2 Pressure PLate 1-07203N W Brake ASSY Backing Plate Brake F106 1-07204N W 5-07205N W ROTOR 1-07206 N 1-07207N W BOLT

104101N M/W ASSY BEB 20403N M/W I.B. 200 3 04104A) ---3 04104N M/W O.B. BEB

## WHEELS BRAKES

12- 08108N WH SUBASSY O/B 1- 08/01N WH INBUARD (M) ZUP Z-08102N W/H OUTBOARD(M) JEP 13 -08109N W/H SUBASSY 1/18-14-08110N WHEEZ ASSY == 3 - 08/03 N DELETED 4-08105N WHEEL ASSY (M) JRP. 5 - 08106N DELETED 6- 08/07NDELETED 7-08150 N WH INBOARD (N) SPE 8-08151 N WHERE ASSY (N) SAP 9- 08152 N WHEEL ASSY (N) 2AP 10-08/53N WHOUTBOARD (N) SOP 08154N WHOUTBOARD (N) JET 12-08/55N WH INBOARD (N) JRP V BRAKES STaTOR Carrier 1-08Z01N 2-0820EN STator PLate Brake F111 3-08203N 4-08204N Pressure PLate Backing PLate FBIII 5-08205N 6-08206N

7-08207N Brake FBIII

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B-0820BN Torque Tube

9-08209 N Torque Tube FB111

08210N DeLeted.

11-08211N ROTETING DISK

12-08212N Backing PLATE

WHEELS

FB-111

13-08108N W/H OUT BOARD BES

14-08109N W/H IN BOARD BES

15 08110N W- H554

BEB

## KC-135 RAKES

1-15101N MW THE CARDOUTBOARD ASSY 2-15102N M/W OUTBOARDV 3-15103N M/W IN BOARD V 4-15150N M/W INBOARD SP8 5-1515IN M/W OUTBOARDV 6-15152N M/W INBOARDY 7-15153N M/W/A554V 3-15154 N M/W OUT BOARD DRS 9-15/55N M/W ASSY 200

BRAKES

1-15201N Backing PLaTe 2-1520ZN Brake KC135 Brake STator 3-15203N 4-15204N Pressure PLate RATOR SegEMENT 5-15Z05N

## WHEELY BRAKE \$ T-33

1-	32102	N WHEEL ASSY .	IPP
2_	. 32 NON	Flange Demountable	JER
3	NEWSE	Wheel Sub Assembly	ممر
4	_IIIOIN_	W/N OUTBOARD MICE	RP
		WH ASSY MICE	

6 11104N W/H INBOARD MLE JAS

BRAKES

1-32201N Brake 7-33

32202N ROTOR

#### T-38

#### BRAKES

1-33201N Brake ASSY T-38

2-33203N TORQUE PLATE

3-33204N Carrier + Lining

4-33205N DISK PLate

5-33202N Wear PLate

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UN 15161 A (5)	08519N	36007N
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38203 N	(15) -16267A	36010 N
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C/N 72898 A (16) 21101 N 21103N. 21104 N 21150 N 21151N RIISAN 21153 N 2154NV 21155 N 21156N 21157N 21158 N 21159N 2116010 211612 21162 N

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(5)

15201 N

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(82)

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CNID  173134-17239 A - 6967A  174514-17237A-17245A  -17348A  15013 N  15013 N  15014 N  15015 N  15016 N  15020 N  15021 N  15022 N  15023 N	150534 N N N N N N N N N N N N N N N N N N N	(1) C/N 17142A - 17143A 69155A  16001N 16003N 16005N 16005
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21213N	37703NV
2121410	3770410
212151	37705N
21216N	3.7706N
	3770710
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(18)	Anna Part Con
13000 N	1) 21 CEQ A - 26560 A
13001 N	UN 26559 A - 26560 H
13002 N	36203N 36217N 36230N
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13003 N 13005 N	3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3
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13013N	October 1
13014N 13015N	36214N /2(22EL)
13016N	36215NV 38001
1 30.01-	36216N 360001N

## WHEEL GROUPINGS TO BE PROCESS CHARACTERIZED

(WCD)	185151	14.00.01	NICITE		OFFIN	
STD, HRS, (MANPGP)	2.67	2.47	2.75		2.09	
PEN	15592A	61575A	90101A	2 5	16267H	
AIRCRAFT	KC-135N	B-52M	"KC-135M" A-10M, C-5M C-130M C-141M	E-34M, F-4M F-5M, F-15M F-16M, F-100M F-106M, F-111M FB-111M	4-10N, C-5N A-10N, C-5N A-7N, C-130N E-3AN, F-4N	
	70	7				
FAMILY CHARACTERISTICS	MAGNESIUM	ALUMINUM - LARGE	ALUMINUM - MEDIUM (MAIN WHEELS)		ALUMINUM - SMALL MEL	
FAMILY NO.	THERMAN 1 6 0	KYLE 2 6 0	²¹ 6 3 2 0		MEL 4 2 0	

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NAME	ALC 00	RCC WHEELS					!	The Hanner Latter	#5 #5
ITEM CODE NUMBER PON/NSN/PN	ACD.	!	REMOV INSTL OP # OP #	11201 A 10 #	ITEM NUMBER PCN/NSN/PN		SAME WCDDATE INSTAL	SAME	
15592A	15153N	88203	5	j   	10 15592A	15152N	88201 Y	T. (67) 4 315 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	~ ( v
155928	15153	88203	ហ	10	10 15592A	15151N	88210 Y		`
695956	16106N	88245	18	10	69595A	16105N	88281 N		
695954	16106N		18	10	69595A	16102N	88281 N		
901019	21101N	88354	2C	10	90101A	21103N	88237 N		
90101A	21101N		2C	10	90101A	21104N	88237 N		
16267A	01156N	88237	S	10	16267A	01155N	88298 N		
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Avita A

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FLU: WHEELS

ALC: UU

1 FM CUDE	AI KUKAFI MUDEL	# # #	W.L. IYPE	FLUPI	PC- 13t	WE FEURI ACT PRODUCTION / WIR # PAX SID TYPE STUCK 1ST 2ND 3ND 4Th ENV WIP HKS	Z D C D C D C D C D C D C D C D C D C D	4 të	# \\ \	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	7 E G
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1 55 YZA	KU-130N	KU-130N 1010ZN	4	∍							
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ひたいとのか	M7.C-9	161U6N	4	>	330	888	181	۳ 4		1 3. 'K	13/8 14,05
かいかいか	MZC-A	161050	3	<b>&gt;</b>							
ひつかりから	M7.5-8	161UZN	4	<b>&gt;</b>							
701014	C-3M	Z1101N	4	<b>5</b>	8422	EE 0.7	1201 0081 8802	1201		13.'B	1378 13.38
70101A	アパーン	Z1103N	4	5							
70101A	いしため	22104N	3	5							
10267A	スサート	U1126N	す	Þ	760	27.7	330	184		13.'8	· 14
1620/A	ンサーエ	U1150	4	5							
1626/A	N7-1	NDC I IO	4	J							

T MON	•		=	2	PERMONE LITTE							`	
r C N	PUN: 15572A		3		} •				MCD:	WCD: 15153N	MUDE	T. T.	BUDDATE:88773
늘*	אככ	UP UESC	UCCU FAC	UP MAND FLUW	T L C &	SK1L	- - - - - -	11ME	K E C I	EWUIP CUDE	)     	. 1 ∰ 	IIME KEU
Z	MENHAM		1.00	; ; ; ; ; ; ; ;	1 } } !	HdU5	! ~	  -  -  -	0.10			 	01.0
ດດວ	MANFEE	SPL	1.00	7		HBUS	N		0.40	U.40 PMUY21			0.40
010	MANPUR	MICH	1.00	ı		CCHU	-		0.02	rMüy4u	-		70.0
070	MANFEF	ASSY	1.00	T				4 U	0.20	-		<b>4</b>	0.20
020	MANPUR	ASSY	1.00	1				13	0.30			U	0.30
070	MANFGF	ASSY	1.00	ī		イエログ	-	4 0	2.00	ZODDEM	-	4 0	2.00
330	MANPUP	Ī	1.00	ı		3507	-	90	0.30	WAUUU3	-	9	0.30
030	MANFEF	Ī	1.00	ı				<b>4</b> 0	0.10			4	0.10
ን አ	MANFUR	S. X.	1.00	1		3807	-		0.10	<b>MAUUUS</b>	-		0.10
<u>አ</u>	MANFIGH	INSL	1.00	ı		3808	-		0.10	EUUUAM	-		0.10
2000	MONPUE	SELL	1.00	1		2H2	-		20.0				

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New Column   New	FUN: 1626/A	H/0								:. 11:1:1:	U11508	コート・ファ	'n.	0 × 1 × 0
NEW COLD   NEW THEN PAID   NEW COLD   NEW			!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!	1				1 1	1 1 1	1	1 1 1 1 1 1 1 1	1	 	1
Particular   D.15   J. UU   D.15	ī *	ארר	UP DESC	UCCU FAC	17 TO			3	<u>-</u>		EU01			Τ. Τ. Τ. Σ. Ο
Properties   Colon	1		018	1.00	1	; ! !	HEUU		! -	. U.		•	1	00.0
Particular	Œ	พูญน	NON	1.00	_						PMU721	-	100	0.0g
PRINCES   1.00   PRIN		W.S.	JEN	1.00			Hピジン	-		⊃.	PROTECT	-	100	10.0
THENTOLED LUND 1 100 1 100 0.08 FINES 1		We) ~	שאי	. uu	ı	∵	ō				FM0425	~	1 C C	† 
Markey   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   1		ואיטי	a to the	1.00	_						アペリアムコ		7 0 0	υ - -
Market		35	UHU	1.00			C DAH	~	20.4	æo. □	FM0426	~	1 U U	) ) )
Manual		איטי	KEM	1.00			HECU	-	100	±0.0				
PARTICLE   LUMB   LUM		W.S.A.	X Fr	1.00	ı		HECU	-	100	0.04	HRNAN1	~	100	t ⊃. ⊃
PROVINCESA   CLOSED 1.000   CLOSED		451	a <del>u</del> n .	1.00	-						FMU971	~	100	D
PROPERTY   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100		H Gill	1007	1.00			KIU3		100	٦.	PMUYU1	-	ກກາ	ς 
Previous		T.C.	PRUC	1.00							HMUYUI	-		7 7
PROPERTY		T C	ואברו	1.90			K LUU	~		•				
		771	1	1111	1	.\					MUSIC	-	100	4
Manual	•	3 7	9 2 4	? =		•					THAILMA	-	100	•
Market		35.	מאַנו	o			1	•		=		• -	? =	? =
Transmistration		35	מ מארים מ	7.00			K103			•	70000	٠.	3 :	) 1
The color		T.	LUAD 1	7.00								٠,	0 :	0 :
Manual		T-GW	UAU	1.00			K101X	-	100	n n n	<b>F</b> iret10	-	100	⊃.
PENNERS   CLN   1.00   K105   60   0.25   FMU416   1 60   0.15   FMU416   1 60   0.15   FMU416   1 60   0.15   FMU416   1 60   0.15   FMU416   1 100   0.00   CMULD   1.00   1 100   0.00   CMULD   1.00   1 100   0.00   CMULD   1.00   0.10   1 100   0.00   CMULD   1.00   0.10   0.10   0.10   0.00   CMULD   1.00   0.10   0.00   CMULD   1.00   0.00   0.00   CMULD   1.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.00   0.		357	Z L S	200.			K103	~	100	0.00	,			
CLN   1.00   KIU5   1.00   CUU002   CUU002   1.00   CUU002   CUU002   1.00   CUU002   CUU002   CUU002   1.00   CUU002   CUU		للزوايد	Z L L	1.00			KICO	-	9	C7.0	FMU410	-	ò	CZ:0
THE COLOR   THE		45.	C.L.	1.00			X100	~	4∪	0.15	Fr10415	-	<b>4</b> ⊃	U.15
The color of the		351	ONL O	1.00							ZODOO	-	100	
PANIFEST   CURPO   1.00   Files   Files   1.00   Files   File		ME L		1,00			K103	-	100	٦.	F10416	-	100	υ.ς
PENNING   PENN		3 3	atta l	1.00							20000	-	100	0.00
Manual		H GW	CUAD	1.00			KICD	-		an.u	<b>FMUYU1</b>	~		ກ ວ.ວ
Manual		1 1	REMO				70WC	~		0.00				
MANIETE   MENTE   ME		Į,	KEM	01.0			JA10	-		0 8.	<b>イバココケノ</b>	~		U.8U
MANUAL   1.00   MANUAL   1.0		1 1	KEMZ				JA10	-		<b>ん</b> /・コ	-M218/	~		٠,×
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16-May-89

STL=STE AL=ALUNIALH MG=MGESTUN TTTA=TTTANTUN SS=S STEE SYN=SYNTHETTC LD=LEAD

KC-135 NLG NOSE WHEEL

BILL OF MATERIALS

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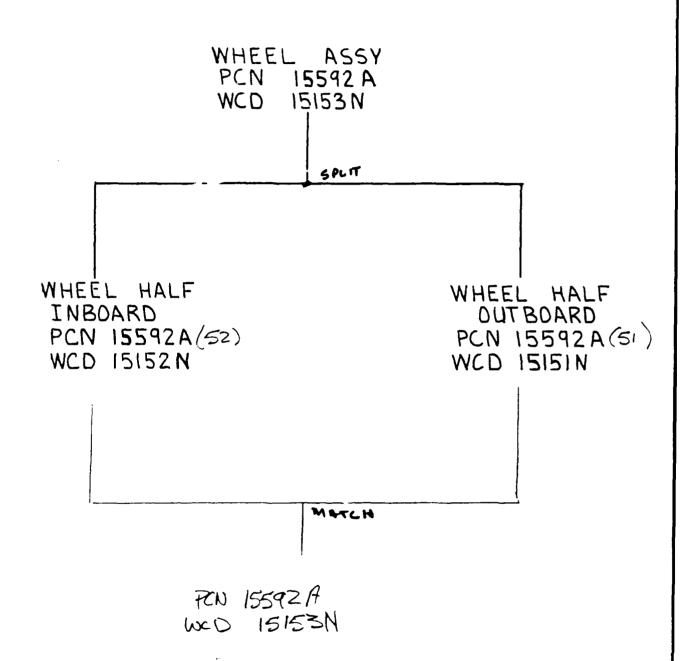
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	==	in.P.L.	IN.S.L.		:.MEEL HALF ASSY. (I.B.)	==									
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		: <b>68C29496</b> -01	:3120001321919	: 98747	:BUSHING,TIEBOLT	112 ARIES									
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	_	:6XB31152-79	:N.S.L.	:98747	:BUSHING, BEARING CUP	==				••					
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	7:::	:211A245-1	1630012427804	173808	:IMPEEL HALF, (1.8.)	55					•-				
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_	12	12124631-2	IN.S.L.		1 MEI BHT, BALANCE	-			-	<u> </u>		-			÷
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	2:::	:211A244-3	11630012427813	173808	WHEEL HALF, (0.B.)	<u> </u>									
		: TR753-03	12640000218295	79934	:.VALVE ASSY, PNEUMATIC	:1 :EA					••				
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	2	Š	12640008105861	179934	:INSIDE, VALVE	 8					•				•
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	2	<b>186-</b> 38	:2640000218295	179934	:PACKING, PREFORMED	.: E3:				•-					
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		1801-070	:5310005966861	172962	:.NUT,SELF-LOCKING				<del></del>	•-					
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JBL	1	CONTROL JO NUMBER DE	-	AIRCRAFT	DESCRIPTION	STOCK NUMBER	Part Number	TECHORDER	6019 FLOW Days
ENS	RIGB	155 <b>85</b> A ~J	J F	-186 MLG	Brake assy	1630-80-165-1029	1518 <del>86-</del> 2	481-4-223	24
	RIGB	15587A -0			BRAKE PRESSURE PLATE	163 <del>0-00</del> -264-0752	329-16-1	4B1-2-483	19
		15592A√-6			WHEEL	163 <del>8-88-4</del> 21 <del>-8</del> 319	211A243R3	443-7-113	30
		15601A -6			BRAKE ASSY	163 <del>0-00-55</del> 3-4734	9550338-1	481-2-1973	28
	RIGB	15603A V -0			BRAKE BACKING PLATE	1630 <del>-80</del> -591-8349	2601844	481-4-263	16
	RIGB	15616A -J		-141 MLG	BRAKE BACKING PLATE	1630-00-567-8162	9533 <b>66B</b>	481-2-373	19
	RIGB	15621A -J	-	-106 ML6	BRAKE PRESSURE PLATE	163 <del>0-60</del> -671-2838	151864	4B1-4-223	16
	RIGB	15639A -0			BRAKE FRESSURE PLATE	1639-01-005-4188	5002564	4B1-2-1 <b>90</b> 3	16
	RIGE	15641AV -3		-4 MLG	BRAKE HOUSING SUB ASSY	163 <b>0-<del>00</del>-276-9849</b>	5001876	4B1-2-1 <b>093</b>	23
	RIGB	15642A -6			BRAKE BACKING PLATE	163 <del>0-01-00</del> 5-4189	5000263	4B1-2-1 <b>66</b> 3	19
ī.E		15643A -(			W-FFL	163 <del>0-0</del> 0-123-8803	17 OCT 88	4W1-8-73	22
	RIGB	15644A -		-15 MG A/B	BRAKE HOUSING	163 <del>8-88</del> -123-88 <b>86</b>	5 <del>00</del> 22 <b>69</b>	481-2-1123	16
	PRIC	15651A -		-15 NLG	WHEEL	163 <del>0-00</del> -558-2584	5 <del>00</del> 096 <del>0-</del> 2	4N3-8 <b>-23</b>	29
	PRIC		-	F-15 ML6	WHEEL	1630-01-005-4262	5000 <b>864</b>	4W1-8-73	29
ENS	COOP	15677A		A-7 MLG	STRUT ASSY	1620-01-174-1655	8121617-36	451- <del>98-</del> 3	30
ENS	COOP	15678A		A-7 MLG	STRUT ASSY	1628-01-174-3179:	8121917-19	451-98-3	•
	PRIC			A-10 NLG	WHEEL	163 <del>8-88</del> -596-9637	3-1358	443-4-433	16
ENS	RIGB			C-5A MLG	BRAKE ASSY	1630-01-041-4570	2-1179-4	4B1-2-1663	26
ENS	RIGB	15728A -		C-139 MLG	BRAKE HOUSING	163 <del>0-80</del> -937-6664	9543433	4B1-2-1 <b>60</b> 3	16
ENS	RIGB	15744A -		F-15 MG A/B	BRAKE ASSY	1630-01-050-5274	5000913-12	4B1-2-1123	13
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ENS	PRIC	,		F-16 MLG	WHEEL.	1630-01-038-9239	5003062	4W1-7-1363	20
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30P	POLL			C-141 MLG	FORWARD LINK	162 <del>8-88</del> -927-2681	3616613-111	451-73-3	21
30P	COOP			C-111 MLG		1628-81-183-7747	7729965-10	451-87-3	<b>32</b> ,
ELE.	COOL			A-37 ML6	BRAKE HOUSING	1639-91-124-2873	19 OCT 88	4B1-2-1 <b>82</b> 3	25
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ENS		16123AV			BALLSCREW	162 <del>9-99-</del> 677-6681	165 <b>6</b> E412	1653-2-48-23	29
_		B 16136A	_ ,	E-JA MLG		1630-01-034-5387	9542482	481-2-1153	13
ART				F-4	CENTERLINE ADAPTER ASSY			1F4C-3-1-4	16
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## KC-135 NOSE WHEEL



KC-135 PCN 15592A WCD 15153N

TN INDUCT 5 SPLIT WHEEL WCD 15151N WCD 15152N DISASSEMBLE CHILLS, 5A 5A DISASSEMBLE CHILLS, WEIGHTS, KEVS, ET WEIGHTS, KEYS, ETC. HEAT To 150°F-6 6 HEAT To 150°F -REMOVE BEARING CUP REMOVE BEARING CUP & STAMP WCD & STAMP WCD CHEMICAL CLEAN 7 7 CHEMICAL CLEAN REMOVE FROM 7A 7A REMOVE FROM CONVEYER CONVEYER BLAST CLEAN 9 BLAST CLEAN 9 LOAD ON 9A 9A LOAD ON CONVEYER CONVEYER MAGNESIUM CLEAN /3 13 MAGNESIUM CLEAN

15 f 15A	PENT INSPECT	15 <del> </del> 15 A	PENT INSPECT
15B	UNLOAD FROM CONVEYER	158	UNLOAD FROM CONVEYER
16	EDDY CURRENT INSPECTION	16	EDDY CURRENT INSPECTION
18	BEAD BLAST	18	BEAD BLAST
19	LOAD ON	19	NICK & BURR
	CONVEYER	40	INSPECT
19A	MAGNESIUM CLEAN	40A	ROUTE FOR REPAIR
30	REMOVE FROM CONVEYER	47	METAL SET
30A	NICK & BURR	60	REAM HOLES
40	INSPECT		
40A	ROUTE FOR REPAIR	70	MACHINE SURFACE
47	METAL SET	70A	CHEM CLEAN
60	REAM HOLES	80	PENT INSPECT
		100	BEAR BORE MACHINE
70	MACHINE MATING SURFACE	120	SEAT REPAIR
70A	CHEM CLEAN	130	BOLT HOLE REPAIR
80	PENT INSPECT	150	VALVE STEM REPAIR
90	BEAR BORE MACHINE	170	Dow 7
110	SEAT REPAIR	180	LOAD

	<b>Y</b>
130 BOLT HOLE REPAIR	180A CLEAN
140 GROOVE REPAIR	180B PROCESS (IMPREGNATE)
170 Dow 7	180C CLEAN
180 LOAD	180D CURE
180 A CLEAN	180E CLEAN
180 B PROCESS (IMPREGNATE)	185 INSTALL CUP
180C CLEAN	190 MACHINE CUP
180 D CURE	195 INSTALL BUSHING
180 E CLEAN	220 INSTALL BUSHING
190 INSTALL CUP	260 INSPECT
195 MACHINE CUP	265 HEAT WHEEL
200 INSTALL BUSHING	265 A INSTALL RACE
205 INSTALL CUP	265 B UNLOAD FROM LINE
210 MACHINE BUSHING 215 INSTALL BUSHING	270 LOAD ON PAINT LINE
220 INSTALL BUSHING	Z70A WASH
260 INSPECT	270B MASK
265 HEAT WHEEL	270C PRIME
265 A INSTALL RACE	270D DRY

•			<b>T</b>
265 B	UNLOAD FROM	270E	MASK
	CONVEYER	270F	1ST PAINT
270	LOAD ON PAINT LINE	270G	ZNO PAINT
270A	WASH	270 H	Dev
270B	MASK	280	STRIP MASK
270C	PRIME	280A	UNLOAD FROM LINE
270 D	DRY	280 B	BALANCE
270E	MASK	282	ASSEMBLE DETAILS
270F	IST PAINT	300	FINAL INSPECT & MOVE
2706	ZND PAINT		
270 H	DRY		
280	STRIP MASK	•	
280A	UNLOAD FROM LINE		
280B	BALANCE		
282	ASSEMBLE DETAILS		
300	FINAL INSPECT & ME	DUE	
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	10 MATCH- UP		, ,

Assemble WHEEL HALVES

- V 30 TOUCH UP PAINT
  - 98 VERIFY WCD COMPLETENESS
  - 99 FINAL VISUAL INSPECT
- 9999 SELL

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15. DISPATCH	PERF RCC/OP	17.	WORK TO BE ACCOMPLI		18.	19.	20.
STATION	NO.	NICK 8	8 BURR		MECHANIC	001 MN	<b>d</b>
		REMOVE	E TORQUE VALVE EX	CEPT DRY		002 04	
	EQIP*		E 500 INCH POUNDS	r e		003 NB	0.4
		Ensus:	SED ON WHEEL HALV * * * N O T E			<del> </del>	
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		IAW T   *C/P	.O. 4W3-7-113 MOVE		1		
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		<del></del>	IZE BRG BORE I.D.				
		*CZP ≀	MATH HET	4.362 MAX			
		1021	110 v t				
69.	047	METAL.	SET IAW T.O.			001 Miv	PRA
*	.05	*C/P /	MOVE			002 01 003 BE	) D1
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J69 1	060	1	TIE BOLT HOLES TO SION .447 MIN .45		,	001 MN	PRA
	.15	PAGE (		7 144 14 TELLA	*	003 DR	02
<del>/</del> 0	020	*C/P /		2 0 5 7 15		AA4 200	Ti F) A
169	070	1	<mark>NE MATING SURFACE</mark> NG SURFACE IAW PA			001 MN	PKA
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1			TAKE PRODUCTION :		*		
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	66	PAGE 8	8 & AF DWG 33B311			002 01	
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1		IAW 63B31					002 01	
~	.05	*CZP MOVE				}	003 MV	1þ4
69	130	TIE BOLT	HOLE REPAIR	IAW PA	GE 7 AND	<del>                                     </del>	001 MN	PRA
,	.59	FIG 5					002 01	
-	1	*CZP MOVE					003 DR	D2
9	150	li .	M HOLE REPA		<del></del>		001 MN	PRA
1	.03	P/N 211A2 IAW PAGE	43M2 & P/N 9 etg 4	211A240	BM3 ONLY		002 01	
	64	*CZP MOVE	/ 110 Q					
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69	1.85	1	UP INTO BEA	ARING BO	RE		001 MN	1
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•	,61	ASSEMBLY P/N N.P.L		- ·	TOVE TOVE	1	002 01	
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259	195	BEARING B	DEHIN <b>E</b> AND	GUP ASS	CZP MOVE		001 MN	
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21. FIN/	AL DESTINATION	N 22.	COORDINATION/II	VITIATING PC	C SIGNATURE/D	ATE	23. DOCU	MENT/S
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5. DISPATCH STATION	16. PERF RCC/ NO	0P 17.	WORK TO BE ACCOMPLISHED		18.	19.	20.
69	220	IŅSTALL	TIE BOLT HOLE BUS		MECHANIC	001 MN	" <b>o</b> " ?RA
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<b>¥</b> 3	265	PZN29520	STALLATION )	*C/P MOVE		001 MN	
	71					003 RI	•
1.3	270	PAINT				001 MN	í
	*REQ)	O* *CZP MON	VE.			002 09 003 BS	
13	280	BALANCE				001. MN	1
	*REQI	D* *C/P MO\	PE.			002 07 003 WB	•
13	282	INSTALL	SEALS & RETAINERS			001. MN	PGP
	*REGO	*CZP <b>MO</b> V	)E	:		002 07 003 WA	D3
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13	310	FINAL PR #C/P MOV	KODUUT VISUAL ING KE	TEUTION		001 mM 002 07	r tel ^e
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15. DISPATCH	16. PERF RC	17 C/OP				18.	19.	20.
STATION	NO.		WORK TO BE ACCO	MPLISHED	<del></del>	MECHANIC		
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7 PART NU	MBER	8 TECH DATA			9. ITEM SER	IAL NO.
10 MODEL-C	ESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL		L	· · · -
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15. DISPATCH	16. PERF RCC/OP	17. WORK TO BE ACCOME	216.250	18.	19.	20.
STATION	NO.	SECOND MAG CLEAN FOR		MECHANIC	001 MN	ુલ⊌ •••••
9.	ALKEOD*	& BURR	*CZP MOVE*		002 04 003 NB	
A. 18	*REQU*	NICK & BURR REMOVE TORQUE VALUE E TORQUE 500 INCH POUNT EMBOSSED WHEEL HALVES	18	<b>4</b> :		
1 Y - 1		E & I			001 MN	PGW
	*REQD*	TIE BOLT HOLE I.D. O. TIE BOLT WALL THICKNE (SEE IDENT NOTE)			002 04 003 EI	1
-		1ST OVERSIZE BEARING 5.116 MIN TO 5.117 MA 2ND OVERSIZE BEARING 5.237 MIN 5.242 MAX. *C/P MOVE	4X			
/69	. 047	METAL SET IAW .T.O.			001. MN	PRA
1	.32	*C/P MOVE			002 01 003 BE	01
159	050	REAM TIE BOLT HOLES T	<del></del>		001 MN	RA
<b>(</b>	,15	CORROSION .447 MIN .9 PAGE & *C/P MOVE	iái dl xam 83	41	002 01 003 DR	02
1. tsfi	070	MACHINE MATING SURFACE			001 MN	PRA
<b>,</b>	, 03	SEALING SUPFACE IAW P *C/P MOVE	•		002 01 003 LE	
		(TYPE 1 METHOD C)			001 MN	
	,03	HETER MACHINING FOR C 7 PARA (3) *C/P MOVE			002 05 003 ZY	
41		* * * * * * * * N O T E IF LAST NOI OPERATION HERE, TAKE PRODUCTION (CONTINUED)	IS COMPLETED	38: - 38:	23. DOCU	MENT/SN
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<i>\$</i> 9	090	BEARING BORE REPAIR (INBOA	RD) IAW	OO1 MNPRA
•	> ,31	PAGE 8 & AF DW0 63B31152		002 01 003 MVD4
	/ ) -	W. 1 (1W/7 b)		VV0 NV04
69	110	BEARING BORE SEAT REPAIR (	INBOARD)	001 MNPRA
1	.03	IAW 63B31152		002 01
	.07	*C/P MOVE		003 MVD4
169	130	TIE BOLT HOLE REPAIR IAW F	AGE 7 AND	001 MNPRA
	.66	FIG 5		002 01
Ą	, ••	*CZP MOVE		003 DRD2
69	140	BEARING BORE & LOCK RING O	ROOVE:	001 MNPRA
	SAMEE	REPAIR (INBOARD) IAW FIG 5	B &	002 01
•	Pide	PAGE 10B PARA X-1		003 LVD2
	A Free Sparse	TREAT (DOW 7)		001 MNPGW
		*CZP MOVE		002 03
	*REQU*			003 MCD4
13	180	IMPREGNATE		001 MNPGP
F		*CZP MOVE		002 07
	*REQD#			003 MID4
69	190	INSTALL CUP INTO BEARING E	ORE	OOL MNPRA
7		BUSHING		002 01
L		P/N42620	CZP MOVE	003 BED1
		P/N63B31152-79		
<i>;</i>				
69	195	MACHINE O.D. OF BUSHING AN	N CUP	OO1 MNPRA
	A5	ASSEMBLY	*C/P MOVE	002 01
1	·	P/N N.P.L.		003 LED9
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69	200	INSTALL	BUSHING AMD COL AS	OTMI YES		901 MM	<u> </u>
	ar .		BORE	*C/P MOVE		002 01	ı
$\rightarrow$		P/N N.S	· L ·			003 BE	01
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1	1	AND LOC   P/N 426	K RING BUSHIN <b>g</b>	*C/P MOVE		002 01	1
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19	210 Ø 0	X	O.D. OF BUSHING AN	i		001 MN	
<b>/</b> •	3/26	ASSEMBL'		*C/P MOVE		002 01 003 LE	•
بخ ^و	215	N.	BUSHING AND CUP AS	1		001 MN	1
•	100	BEARING P/N N.S		*C/P MOVE		002 01 003 BE	
/	U						
69	220	INSTALL	TIE BOLT HOLE BUSH	11MG		001 MN	
	.83	*C/P MO				002 01 003 BE	
4.63	25 1 13	45-53-351 451-00 A-4	A 1 TAND TO COMP TO A 1 A 1 FO A 1	o do prince por tre		0.04 3/31	
13 -	260	*CZP MO	AL INPECTION AND AS Ve	ommette 		001 MN	l .
	*REQD*		-			003 PF	
<u> </u>	265	RACE IN	STALLATION	CZP MOVE		001 MN	5 (5)5
	حي	P/N 426				002 07	
/	, 'D'					003 RI	06
13	270	PAINT				001 MN	2 <u>G</u> P
	aga po leti etti etti etti a	*CZP MO!	VE.	ĺ		002 09	
	*REQD*			Ì		003 85	02
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71.3	282	1	SEALS & RETAINERS			001 MN	PGP
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DATE E8145 15153N WORK CONTROL DOCUMENT (MEDS) B DATE COMPLETED 3 QUANTITY 4 PRODUCTION SEC RCC 2 JOB ORDER NO 5 DATE SCHED MNPGW 55924 TECH DATA 9 ITEM SERIAL NO 41-1-51 443-7-113 TO MODEL-DESIGN-SERIES 11 STOCK NUMBER 12 OPTIONAL KL-135 NOSE 14 NOUN 13 SERIAL NUMBER WHEEL ASSY PERF RCC'OP DISPATCH MECHANIC WORK TO BE ACCOMPLISHED P/N NSN C/N 211A243M 1630005166758 37985A 2114243M2 1630006896014 15143A <211A243M3 1630204212319 155924 ***** UNIT CUST: \$242.10 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 DOW IAW MIL-M-3171A ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN TELS DOCUMENT HAVE PEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MCVE; FOR MOVES LETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROUBLURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE PUTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PERCAUTIONS MUST BE EMOLPYED TO PRECLUCE INJURIES. *REQD* (MANDATORY REQUIREMENT (LONTINUED COORDINATION/INITIATING RCC SIGNATURE/DATE DOCUMENT/SN 22 FINAL DESTINATION FUNCTIONAL CODE DISPATCH 15153N

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AFLC FORM 958 NOV. 80

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69	130	FIG	MOVE	REPAIR 17	W PAGE	7 AND			
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69	195	BEAR	ALL BUSHING ING BORE N.P.L.	AND CUP		MOVE			
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59	<b>VEV</b>	REAM TIE ECLT			7:		
		CORROSION .44	7 MIN .453 M	AX IL IAW			
	Kin ]	PAGE 6 *U/P MOVE			N. A.		
59 <u> </u>	276	MACHINE MATIN				P _i	
		SEALING SURFA *C/P MOVE	CE IAW PAGE 9	9			
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3		Ţ	K			FA	SU	POR	ī		< <u>\$</u>					BASE HOURS	PFD TIME	STD HOURS	DLY	PCT C
			HB HB		-		-	58333		.00	PERCENT ENGR 211A243M 211A243M2 211A243M3		16300 16300	PART NUMBI	KC135N ER/NSN	.69	.000	. 69	<del></del>	0
0005	5	Ε				R	WB-I	)₩ <b>-</b> 05	5 1	.00	DIS MED WHL REN RPL PAPR	(TIE BC	ILT NO B/k	DISASSEMB		.157 .15704 .0100:	<b>,</b>	.209 .196 .012		30
	0010 0020 0030	E	HĐ	01		25 51 Ri	WB-!	3C-01 1H-02	1 2	.00 2.00 .50		NG CUPS	F/CLENINS	REMOVE BEA	ARING CUPS		.0 <del>9</del> 7		.3	70
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	15	59	2A		KC13	5	N WHL 2	11A243				PGW				31050		
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	7				2	7		1.00			NI	CK & BURR WHEEL	MED/HALF	.250	.068	.319		62
						RL	RS-NC	1.00	NICK & BURR	PTS-CON	IST F/PREP			.02312		.029		
	0020	N						1.00				CK & BURR WHEEL	MED/HALF	.21687		. 275		
						RJF	-FW-R1		REM RPL PAPR					.01001		-012		
	)				1	5		1.00			Ε	k I AND ROUTE WH	EEL.	.167	.025	. 193		38
	0010							1.00				I AND ROUTE WHEE	I HALF	.14919		.171		
														.00633		.009		
	0030	_							REM RPL PAPR					.01001		.011		
9000	)		DI	01	1	5		.01			LA	OR STD HISTORY-	MORE	.000	.000	.000		0
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	0020								3 JUN	E 1983	OLD TIME WAS	5 .50						
	0030								REQ D	. BALLI	ngham							
	0040								03DEC84 2 YE	ar revi	EW/NO TIME (	HANGE						
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RCC PRD NROP NR

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							L1A243	43		RCC	MNPGW		4H3-7-113		8	31050		
		TK	#8	AF	A SI							CHIPCH ENCUT	> AL	BASE	PFD TIME		ru v	A CCT C
	3165	ם ב	۸ 	 	1 CL	ETENI	FHL:		2:0UCD			SUFFLERENT	ML.	HUURS	1 I FIE	HOURS	UL. 1	PCT C
WE:52	Ε	N D	I EA	5	J	88335	1.00	PERCENT	ENGR 12.3		E&I WAL	HLF I.B. K	C135N	.51		.51		
000	1	D	I 01	0	0		.00				PART N	IMBER/NSN		.000	.000	.000		0
	0010							211A245	·	NSL								
	0020								-1									
001	9	D	01	2	7		1.00				NICK &	BURR WHEEL	MED/HALF	.250	.068	.318		62
	0010	Ε	•		RLG-	RS-NC	1.00	NICK &	SURR PTS-CO	INST F/PRE	ာ			.02313		.029		
	0020	N					1.00				NICK &	BURR WHEEL	MED/HALF	-21687	7	. 275		
	0030	Ε			RJP-	PW-R1	1.00	REM RPL	PAPRWRK SI	ign off do	C			.0100	!	.012		
004	0	D:	01	1	5								EEL		.025	.193		38
	0010												L HALF	. 14919	7	.171		
														.00633	5	.009		
	0030	Ε		,	RJP-	PM-31	1.00								1	.011		
9000	)				5		.01				LABOR S	TD HISTORY-	HORE	.000	.000	.000		0
	0010								TIME NEEDED	TO INSP	& N & B							
	0020								3 JUNE 1983	OLD TIME	WAS .50	٢						
	0030							1	REG D. BALL	.INGHAM								
	0040							03DEC84	TIME NEEDED 3 JUNE 1983 REG D. BALL 2 YEAR REV	IEW/NO TI	ME CHANG	E						
	0900								e/Maneaa									

FRD NROP NR

7MNPGW1	55924	WH	151							-					٠					
0000		559 1 °				35	ABOR SI	211		_	RESOURCE		AND METH	OD ANALYSIS	12.56/88 4W3-7-113			1- <b>DY-H45</b> 31050	PAGE	0001
Greek	STEF	Ţ	K	#R	A	FA	A/R RE SUPPOR ELEMEN	RT	OCC FACT	< <del></del>	STORED	DESC		SUPPLEMENTAL	<del></del> >	Base Hours	PFD TIME	STD HDURS	ĎΓÀ	A PCT C
WM151	-		KI KI		_	15	J 8833	35	1.00	PERCENT E	NGR 27.9		DON 7 WH	L HLF 0/8 KC BER/NSN	135N	.18	.000	.18		0
	0010									211A244 211A244-1		N.S. N.S.								
	0030 0040			٠						211A244-2 211A244-3		N.S. 1630	L. 012427813							
0170	0 0010		ΚI	01		27 Rh	12-CT-0		1.00 1.00	CHEM TREA	TAMED M		DOW MAG.	WHEEL MED		.147 .03118		.187 .039	.7	100
	0020 0030						S-CL-* P-PW-R	_		LOAD & UNI						.21200		.134		
9000	0 - 0010 - 0020	)	ΚI	10		27				03DEC34 2 18JUL85 M		IEW/NO TI				.000	.000	.000		0

D. PARKER TECHN MANEAA

TO INTERROSATE LABOR STANDARDS, INPUT

RCC PRD NRCP NR  $\langle --- \times --- \times --- \rangle$ 

0900

		592A		K2135	N MHL 2			ON RESOURCE		AND MET	THOD ANALYSIS	12. 23/88 4W3-7-113			-DY-H45 1050	PAGE	0001
OPER CUR	TECH	TK	#R	A FA	A/R REV SUPPORT ELEMENT	GCC FACT	< <del></del>	STORED	DESCR	RIPTION	SUPPLEMENTA	> NL	BASE HOURS	PFD TIME	STD Hours	DLY	PCT (
WH152	-	N K	I EA		J 88335	1.00	PERCENT	ENSR 27.9			IHL HLF I/B K IMBER/NSN	C135N	.18	.000	.18		0
	0020						211A245		16300	1242780							
0170	) -0010		1 01		WB-CT-03	1.00		eat a med ha		DOW MAG	), WHEEL MED		.147 .0311	•	.187 .039	.7	100
	0020 0030				LS-CL-MI JP-PW-RI			UNLOAD CARRI PAPRWRK SIG		;			.2120	-	.13 <del>4</del> .012		
9000	) (010	K	01	27		.01	O3DEC94	2 YEAR REVI			TD HISTORY		.000	.000	.000		0

18JUL85 MOVED N&B TO HB SKL (TM WAS 1.47

D. PARKER TECHN MANEAA

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NROP NR

0020 0900

TYNENAL	5559N	A151						$\sim 10^{-3}$		√ <b>~</b>					
					L	ABOR STA	NDARD	OPEN ION RESOURCE	STANDARD AND HETHOD	ANALYSIS 1 6/88	A-EO	16B-191	1-DY-H45	PAGE	0001
	15	5926	ł	ΚC	135	N WHL 2	11A243	13	RCC INPNA	4W3-7-113	•				
OFER	TECH	SS	}	W F	F.F	A/R REV	)								
الما ي		TB	( #	R A	FA	SUPPORT	000	<b>(</b>	DESCRIPTION	·>	EASE	PFD	STD		A
	STEP	DL		K C	DC	ELEMENT	FACT	STORED	SUP	PLEMENTAL	HOURS	TIME	HOURS	DLY	PCT C
NA151	<u> </u>	E	ΒE	A 2		J 88335	.20	PERCENT ENGR 99.9	NDI WHL HLF	O.B. KC135N	.81		.16		
000	1	9	вο	1	15		.00		PART NUMBER	/NSN	.000	.000	.000		0
	0010							211A244	N.S.L.						
	0020							211A244-1	N.S.L.						
	0030							211A2 <b>44-2</b>	N.S.L.						
	0040							211A244-3	1630012427813						
0080	)	D	B 0	l	11		. 46		ZYGLO WHEEL	MED	1.591	.081	.812	.7	100
	0010	E			Z!	.6-ND-72	12.00	ZYGLO INSP MED PART	BLD 507		.13177	•	1.755		
	0020	Ε			RJ	IP-PW-R1	1.00	REM RPL PAPRWRK SIGN	NOFF DOC		.01001		.011		
9000	)	Ð	B 0:	!	13		.01		LABOR STANDA	ARD HISTORY	.000	.000	.000		0
	0010							7NOV85 ADDED STEP (	0040 Degrease (OLD S	TD .65>					

KERRY COOP MANEAA TECHN 73357

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  $\langle --\times --\times -- \rangle$ 

0900

TMNPNA1	15	592A	_	KC1		ABOR STA N WHL 2		ОРЕКні I( M3	ON RESOU	rce st		AND ME INFNA	THOD ANAL	.YSIS	16/88 443-7-113		46B- <b>10</b> 1	1-DY-H45	PAGE	0001
CPER	TECH STEP	TK	#1	A I	FA	A/R REV SUPPORT ELEMENT	330	<	STOR		- DESCR	RIPTION	SUPPLEM	ENTAL	<del></del> >	Base Hours	PFD TIME	STD Hours	DLY	A PCT C
NA152 000		E DI	B E/ B 01	_	00	J 88335	.00	PERCENT 211A245 211A245		.9	NSL		HLF I.E IMBER/NSN		35N	.81	.000	.16	<del></del>	0
0080	0 0010 0020	ξ	B 0 <u>1</u>			G-ND-72 P-PW-R1		ZYGLO IN			LD 507		HEEL MET	1		1.591 .1317 .0100		.812 1.755 .011	.7	100
9000	0 0010 0900	-	3 01	1	13		.01		ADDED S		40 Desa	EASE (0	STANDARD ILD STD . 17		RY	.000	.000	.000		0

RCC FRD NRCP NR  $\langle --- \times --- \times --- \rangle$ 

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/01/89 A-E046B-MM1-DY-M45 PAGE 0001

		592A						M3		RCC	MNPNA		4W3-7-113	3				
PER						A/R REV												
		T K	#5	4.5	FA	SUPPORT	030	<- <del></del>		DESC	RIFTION		>	BASE				
	JEP C	D L	N 	( C	I:C	ELEMENT	FACT	5	TORED			SUPPLEMENTAL		HOURS		HOURS		PCT C
, <b>k</b> ,												KC135N						
											NDI TIE	BOLTS 1ST TIM	Ε	1.005	.014	,145		36
	0010	Ε			21	G-ND-MS	11.00	MAGNAGLO INS	P SHALL	OBJECT				.09138		1.115		
002	0	D	B 01		11		.13				NDI DRI	VE KEYS 1ST TI	ME	.822	.012	.119		30
	0010	Ε			ZL	G-NII-MS	9.00	MAGNAGLO INS	P SHALL	OBJECT				.09138	}	.912		
200	0	D	B 01		00		.00				PART NU	HBER/NSN		.000	.000	.000		0
	0019							WCD ROUTED P 2110244 2110244-1 2110244-2 2110244-3	ARTS RE	QUIRING	FPI							
	0020							211/1244		MSL								
	0030							2116244-1		NSL								
	0040							211A244-2		NSL								
	0050							211A244-2 211A244-3		1630	01242781	3						
	0030							211A245		NSL								
	0070							211245-1		1630	01242780	4						
200	1	ņ	B 01		11		1.00				FPI 1ST	TIHE		.263	.029	.293	.8	7 <b>3</b>
	0030	Ε			ZL	G-ND-Z2	2.00	ZYGLO INSP M	ED PART	BLD 507				.13177	ı	• <i>2</i> 92		
200	3	D	01		11		1.00				EDDY CU	RRENT WHEEL		.083	.009	.093		23
	0010	Ε			ZL	G-ND-E3	1,00	SET UP MACHI	NE -EDI	Y CURREN	Ţ			.03866		.042		
	0020	Ε			ZL	G-ND-EI	3.00	EDDY CURRENT	~ SURF	ACE SCAN				.00078	1	.002		
	0030	ξ			ZL	G-ND-EO	1.00	PROCESS TIME	- PROE	RE TRAVEL				.00033		.000		
	0040	Ε			ZL	G-ND-E4	1.00	S.U. PROBE H	OLDER P	RAD. SCAN				.00392	•	.009		
	0050	Ε			ZL	G-ND-E5	1.00	MATERIAL HAN	DLING	TEST ARE	A			.00371		.004		
	0060	Ε			ZΡ	L-PW-L1	1.00	ENTER INFO I	N LOG B	iook				.01951		.021		
	0070	Ε			RJ	P-PW-R1	1.00	REM RPL PAPR	WRK SIG	IN OFF DO				.01001		.011		
		D.	R 01		13		.01				LAROR S	TANDARD HISTOR	Y	.000	.000	.000		0
	0010							7NOV85 ADDE	D STEP	0040 PEG	REASE (O	LD STD .65>						
	0900							7NOV85 ADDE KERRY	COOP N	ianeaa te	CHN 7335	7						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

LABOR STANDARD OPERALION RESOURCE STANDARD AND METHOD ANALYSIS 12, .0/88 A-E046B-MM1-DY-M45 PAGE 0001 15592A KC135 N WHL 211A243M3 RCC MNPRA 4M3-7-113 OPER TECH S S W F PF A/R REV STEP DIL KIC DIC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C RA152 S S JA EA 1 J 88327 .20 PERCENT ENGR 98.4 MACH INBD WHL HALF KC-135N 5.80 1.16 .00 0001 JA 01 15 PART NUMBER/NSN .000 .000 N.S.L. 0010 2118245 211A245-1 0020 1630012427804 0047 JA 01 15 .05 METAL SET REPAIR .303 .002 .017 0010 E REW-SU-G1 1.00 S/U FOR BENICH WORK GENERAL .27525 .316 GTE-EP-PC 1.00 SEAL SMALL PART WITH EPDXY 0020 E .021 .01864 0030 E RJP-PN-R1 1.00 REM RPL PAFRNIRK SIGN OFF DOC .01001 .011 0060 JA 01 15 .46 REP TIE BOLT HOLE, RAD DRILL 2.121 .146 1.122 0010 E RDR-SU-R1 .25 S/U TO D/S BOSSES RAD DRILL PRORATE OVER 4 PARTS .56378 .162 0020 E RDR-BO-A1 1.00 0/S BOSS W/STEP RMR RAD DRL .30463 . 350 0030 E RDR-BO-A2 11.00 D/S ADML BOSS STP RMR RAD DR 11 ADML TIE BOLT HOLES .14687 1.857 0040 E RBW-DB-A1 12.00 DEBUR HOLE/CUTOUT BOTH SIDES DEBUR 12 TIE BOLT HOLES .00423 0050 E 5JP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC .01001 .011 0070 JA 01 15 .05 MACHINE MATING SURFACE .605 .005 .035 0010 E RLA-SU-S3 1.00 SET UP SMALL MEDIUM LATHE . 49962 .574 .09095 0020 E RLA-HP-C3 1.00 CHUCK SYMET PART IN 4 JAW .104 0030 S KML-FF-NB 1.00 FACE FINISH 9 TO 10 ADD 1/8 0040 E RJP-PN-R1 1.00 REM RPL PAPRNIRK SIGN OFF DOC 0030 E .00506 .005 .01001 .011 BEARING BORE REP - JIG BORE 0090 JA 01 15 1.00 .886 .133 1.020 0010 E RML-SU-V3 .25 S/U VERT MIL BORE FXTR HDISTPRORATE OVER 4 PARTS 1.03687 . 298 RML-HP-CC 1.00 HOIST HANDLE NO WRAP 2 CLAMP 0020 E .15776 .181 0030 E RML-AL-AB 1.00 ALIGN VERTICAL AXIS RCD .12699 0040 E RML-AL-AC 1.00 ALIGN HOLE TO SPINDLE ROD .07509 .087 0050 E KMM-BA-KC 1.00 BORE HOLE 5.5 X 1.5 GROUP 1 0060 E RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC . 294 25649 .01001 .011 0110 JA 01 15 1.00 .829 .124 BEARING BORE SEAT REP, LARGE .954 0010 E RML-SU-V3 .25 S/U VERT MIL BORE FXTR HOIST PRORATE OVER 4 PARTS 1.03687 .298 0020 E RML-HP-CC 1.00 HOIST HANDLE NO WRAP 2 CLAMP JI6 BORE . 15776 0030 F RML-AL-AB 1.00 ALIGN VERTICAL AXIS ROD .12699 .146 RML-AL-AC 1.00 ALIGN HOLE TO SPINDLE ROD 0040 E .07*6*09 .087 KOMH-BA-KA 1.00 BORE HOLE 5.5 X 1/2 SROUP 1 0050 E .19948 .229 0060 E RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC .01001 .011 0130 JA 01 15 .46 REP TIE BOLT HOLE, RAD DRILL 2.311 .160 1.223 0010 E RDR-SU-R1 .25 S/U TO 0/S BOSSES RAD DRILL PRORATE DVER 4 PARTS 56378 .162 RDR-BO-A1 1.00 O/S BOSS W/STEP RMR RAD DRL 0020 E .30463 .350 0030 E RDR-BO-A2 11.00 O/S ADML BOSS STP RMR RAD DR 11 ADML TIE BOLT HOLES .14687 1.857 KAL-SH-31 12.00 SPOT-FACE OR COUNTERBORE 12 TIE POUT HOLES .02004 .276 RJP-PN-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC .01001 .011 0140 JA 01 15 .46 REARING BORE & LOCK RING REP .508 .035 .269 1.00 0010 N SET UP PENSOTTI .192 .16700 .26 MACHINE BEARING BORE 1.00 0020 E . 29333 RJP-PN-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC/ 0030 E -01001 .011 0040 E RPL-HH-P1 1.00 GET PALLET JACK & MOVE PARTS/ .03815 .043 0190 JA 01 15 1.00 INST CUP INTO BUSHING .077 .012 .089 0010 E RBH-BU-S1 .25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS . 18669 .053 RBN-BU-A4 1.00 INSTALL ONE STRAIGHT BUSHING .02062 .023 0030 E RJP-PW-R1 1.00 REN RPL PAPRINRK SIEN OFF DOC .01001 .011 195 JA 01 15 1.00 MACH BEARING BORE BUSHING .236 .036 .272 0010 E RLA-SU-53 , 25 SET UP SHALL MEDIUM LATHE PRORATE OVER 4 PARTS .49962 .143 .01006 0020 E RLA-HP-C1 1.00 1ST PART IN-OUT SCROLL CHUCK 0030 F KML-TA-JC 1.00 DIA 5.00-6.00 REM .033-.250 .09193 .105 RJP-PN-R1 1.00 REN RPL PAPRWRK SISN OFF DOC 0040 E .01001 .011

0010 E	RBW-BU-S1 .2	5 SET ur TO REBUSH BOSSES	INST BEARING BORE BUSH !	.077 .18669			2
00 <b>20</b> E	RBW-BU-A4 1.0	O INSTALL ONE STRAIGHT BUSHING	6 C INST CUP INTO B B & L R BUSH	.02062		.023	
00 <b>30</b> E	RJP-PW-R1 1.0	O REM RPL PAPRWRK SIGN DFF DO	C	.01001		.011	
							2
			PRORATE OVER 4 PARTS	.18669		.053	
0020 5	RBW-BU-A4 1.0	O INSTALL ONE STRAIGHT BUSHIN	6	.02062		.023	
		) rem ripl papriirik sign off doo	C	.01001		.011	
0210 JA 01	15 1.0	)	MACH BEARING BORE BUSHING	.236	.036	.272	5
			PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1 1.0	) 1ST PART IN-OUT SCROLL CHUC	K	.01006		.011	
003 <b>0</b> E	KML-TA-JC 1.0	DIA 5.00-6.00 REM .033250	<u> </u>	.09193		.105	
0040 E	RJP-PW-R1 1.0	) REM RPL PAPRWRK SIGN OFF DOD		.01001		.011	
0215 JA 01	15 1.0	)	INST BEARING BORE BUSH & CUP	.077	.012	.089	2
0010 E	RBW-BU-S1 .2	S SET UP TO REBUSH BOSSES	FRORATE OVER \$ PARTS	.18669		.05ೱ	
0020 E	R3W-8U-A4 1.0	) INSTALL ONE STRAIGHT BUSHING	6	.02062		.023	
0030 E	RJP-PW-R1 1.0	) REM RPL PAPRWRK SIGN OFF DOO	5	.01001		.011	
0220 JA 01	15 .7·		INST TIE BLT BUSH OTED	.314	.035	.268	5
0010 E	RBW-BU-S1 1.0	) SET UP TO REBUSH BOSSES		.18669		.214	
0020 E	RBW-BU-A4 1.0	) INSTALL ONE STRAIGHT BUSHING	3	.02062		.023	
0030 E	RBW-BU-A3 11.0	INST ADML STRAIGHT BUSHING	G ELEVEN BUSHING	.00886		.112	
0040 E	RJP-PW-R1 1.00	) REM RPL PAPRWRK SIGN OFF DOO		.01001		.011	
9000 JA 01	15 .0	L	LABOR STANDARD HISTORY	.000	.000	.000	0
0010		29AU684 ADD SUB OP 0080 % 00	090 (OLD STD) 1.19				

RCC PRO NROP NR

:<----> 1204567890123456 ELSE PUT IN END

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LABOR STANDARD OPERA ON RESCURCE STANDARD AND METHOD ANALYSIS 12,08/88 A-E046B-MM1-DY-M45 PAGE 0001 15592A KC135 N W-L 211A243M3 REC MNPRA 4W3-7-113 OPER TECH S S W F PF A/R REV TK #R A FA SUPPORT OCC <------ DESCRIPTION -----> BASE PFD STD STEP DIE KIC DIC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C RA151 S E JA EA 1 J 88327 .20 PERCENT ENGR 99.9 MACH OUTBD WHL HALF KC-135N 5.27 1.05 0001 JA 01 15 .00 PART NUMBER/NSN .000 .000 .000 N.S.L. 0010 211A244 0020 211A244-1 N.S.L. 0030 211**A244~**2 N.S.L. 211A244-3 0040 1630012427813 0047 JA 01 15 .05 METAL SET REPAIR .303 .002 .017 0010 E REW-SU-G1 1.00 S/U FOR BENCH WORK GENERAL .27525 .316 GTE-EP-PC 1.00 SEAL SMALL PART WITH EPDXY 0020 E .01864 .021 0030 E RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN DFF DDC .01001 .011 0060 JA 01 15 .46 REP TIE BOLT HOLE, RAD DRILL 2.121 .146 1.122 21 0010 E RDR-SU-R1 .25 S/U TO D/S BOSSES RAD DRILL PRORATE OVER 4 PARTS .56378 .162 0020 E RDR-BO-A1 1.00 0/5 BOSS W/STEP RMR RAD DRL .30463 .350 .14687 FOR-ED-AZ 11.00 O/S ADNL BOSS STP RMR RAD DR 11 ADNL TIE BOLT HOLES 0030 E 1.857 RBW-DB-A1 12.00 DEBUR HOLE/CUTOUT BOTH SIDES DEBUR 12 TIE BOLT HOLES 0040 E .00423 .058 0050 E RJP-PW-R1 1.00 REM RPL PAFRWRK SIGN OFF DOC .01001 .011 0070 JA 01 15 .05 MACHINE MATING SURFACE .605 .005 .035 0010 E RLA-SU-S3 1.00 SET UP SMALL MEDIUM LATHE .49962 .574 0020 E RLA-HP-C3 1.00 CHUCK SYMET PART IN 4 JAM .09095 .104 KML-FF-NB 1.00 FACE FINISH 9 TO 10 ADD 1/8 .00506 0030 E .005 RJP-PN-R1 1.00 REN RPL PAPRWRK SIGN OFF DOC .01001 .011 0100 JA 01 15 1.00 BEARING BORE REP - JIG BORE .886 .133 1.020 19 0010 E RML-SU-V3 .25 S/U VERT MIL BORE FXTR HOISTPRORATE OVER 4 PARTS 1.03687 0020 E RML-HP-CC 1.00 HOIST HANDLE NO WRAP 2 CLAMP .15776 .191 0030 E RML-AL-AB 1.00 ALIGN VERTICAL AXIS ROD .12599 0040 E RML-AL-AC 1.00 ALIGN HOLE TO SPINDLE ROD .07609 .087 0050 E KMM-BA-KC 1.00 BORE HOLE 5.5 X 1.5 GROUP 1 .25649 .294 .01001 0060 E RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC .011 BEARING BORE SEAT REP, LARGE 0120 JA 01 15 1.00 .829 .124 .954 0010 E RML-SU-V3 .25 SAU VERT MIL BORE FXTR HOIST PRORATE OVER 4 PARTS 1.03687 0020 E RML-HP-CC 1.00 HOIST HANDLE NO WRAP 2 CLAMP JIG BORE .15776 . 181 0030 E RML-AL-AB 1.00 ALIGN VERTICAL AXIS ROD .12699 .146 0040 E RML-AL-AC 1.00 ALIGN HOLE TO SPINDLE ROD .07609 .087 0050 E KON-BA-KA 1.00 BORE HOLE 5.5 X 1/2 GROUP 1 .19948 0060 E RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC .01001 .011 0130 JA 01 15 .46 REP TIE BOLT HOLE, RAD DRILL 2.311 .160 1.223 0010 E RDR-SU-R1 .25 S/U TO D/S BOSSES RAD DRILL PROPATE OVER 4 PARTS .56378 . 162 RDR-BO-A1 1.00 OVS BOSS W/STEP RMR RAD DRL 0020 E .30463 .350 0030 E RDR-BO-AZ 11.00 DVS ADNL BOSS STP RMR RAD DR 11 ADNL TIE BOLT HOLES .14687 1.857 KAL-SM-31 12.00 SPOT-FACE OR COUNTERBORE 12 TIE BOUT HOLES 00**40** E .02004 0050 E RJP-PN-R1 1.00 REH RPL PAPRWRK SIGN DFF DOC .01001 .011 0150 JA 01 15 .25 .459 .017 valve stem hole rep rad or .132 3 0010 E RDR-SU-R1 .25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS .56378 . 162 RDR-BO-A1 1.00 DVS BOSS W/STEP RMR RAD DRL 0020 E .30463 .350 .004 0030 E .00423 RBH-DB-A1 1.00 DEBUR HOLE/CUTOUT BOTH SIDES RJP-PM-R1 1.00 REH RPL PAPRWRK SIGN DFF DOC .01001 .011 0160 JA 01 15 .10 valve stem hole ræp rad dr .469 .007 . 054 0010 E RDR-SU-R1 .25 S/U TO D/S EQSSES RAD DRILL PROPATE OVER 4 PARTS .56378 .162 .350 0020 E RDR-BO-A1 1,00 DVS BOSS W/STEP RMR RAD DRL .30463 STL-TH-A1 1.00 TAP HOLE TO 0.25 IN THRO DIA 0030 E .01427 .016 RJP-PN-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC -01001 .011 0185 JA 01 15 1.00 INST CUP INTO BUSHING .077 .012 .089 0010 E RBM-BU-S1 .25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS .053 . 18669

0020 (	=		RBW-BU-A4	1.00	INST DINE STRAIGHT BUSHING	.02062		.023	
0030 1	Ξ		RJP-PW-R1	1.00	INST ONE STRAIGHT BUSHING REM N. L PAPRWRK SIGN OFF DOC	.01001		.011	
0190			15		MACH BEARING BORE BUSHING	.236	.036	.272	5
0010 1	•		RLA-SU-SJ	. 25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	. 49962		.143	
0020 9				1.00	1ST PART IN-DUT SCROLL CHUCK			.011	
0030 8	•		KML-TA-JC	1.00	DIA 5.00-6.00 REM .033250	.09193		.105	
					REM RPL PAPRWRK SIGN OFF DOC			.011	
					INST BEARING BORE BUSH & CUP		.012	.029	2
					SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS			.053	
0020 E	:		RPW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030 5	:				REM RPL PAPRWRK SIGN OFF DOC				
0220	JA	01	15	.74	INST TIE BLT BUSH CTBD	.314	.035	.268	5
0010 8			RPW-PU-S1	1.00	SET UP TO REBUSH BUSSES	.18669		.214	
0020 E	:		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030 E			RBW-BU-A3	11.00	INST ADML STRAIGHT BUSHING ELEVEN BUSHING	.00886		.112	
0040 E	:		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000	JA	01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010					29AUS84 ADD SUB OP 0080 % 0090 (OLD STD) 1.19				

RCC PRD NROP NR

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?!NFSP15592A00010 15592A K	LABOR STANDARD C135 N WHL 211A24		DARD AND METHOD ANALYSIS 12,00,68 RCC MMPGP 443-7-113			-DY-H45 1050	PAGE 0001
TK #R	F PF A/R REV A FA SUPPORT DC C DC ELEMENT FAC	· ·	DESCRIPTION> SUPPLEMENTAL		YFD TIME	STD Hours	DLY PCT C
00010 S E YH EA 0001 YH 01 0010 0020	-	211A243M 211A243M2	ASSY WHL KC135N PART NUMBER/NSN 1630005166758 1630006896014 1630004210319	.000	.000	.06 .000	0
0030 9020 YH 01 9010 E		211A247M3 00 00 INSTL UNOBSTRUCTED TIE 00 REM RPL PAPRWRK SIGN O	FINAL WHL ASSEMBLY MED/NORK BOLT	.069 .00975 .01001	.014	.084 .047 .036	100
9000 E 9000 YH 01 0010 0020 0030 0031 0032 0900		ດາ	LABOR STANDARD HISTORY 1 SLANLOAD LINE(OLD STD> 1.68 2 0013 (OLD STD> 1.76 NO TIME CHANGE CODE FROM YG TO YH	.000	.000	.000	0

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, and office )			-	KC					À RESOURI			THOD ANALYSIS				L-DY-M45 31050	PAGE	0001
	ECH					A/R REV									•			
		ΤK	#	R A	FA	SUPPORT	CCC							BASE	PFD	STD		A
ST	TEP	D L	<u> </u>	K C	DC	ELEMENT	FACT		STORE	D 		SUPPLEMENTAL	•	HOURS	TIME	HOURS	DLY	PCT C
PP153	Ε	N 3	S E	A 5		J 88333	1.00	PERCENT	ENGR 37.	9	TOUCH (	JP PAINT WHL H	(C135N	.41		.41		
0001		3.	S 0:	1	00		.00				PART N	JMBER/NSN		.000	.000	.000		0
00	010							211A243	Ħ	10	300051667	58						
00	20							211A243	M2	10	30006 <b>896</b> 0	14						
00	020							211A243	13	16	3000421031	19						
0030		3	5 01	l	25		1.00				PAINT	rouch up sh 🖫	MED	.063	.016	.080		19
00	10	Ε			Ri	NB-FT-02	1.00	FINAL &	TUCH UP !	MED/SML I	HEL			. 05399	5	.067		
00	20	Ε			R	JP <del>-PW-R</del> 1	1.00	REM RPL	PAPRWRK S	SIGN OFF	DOC			.0100	1	.012		
0098		39	5 01		25		1.00				FINAL A	ACCEPTANCE OF	W.C.D.	. 132	.033	. 166		40
00	10	N					1.00				FINAL			.08000	)	.100		
00	20	Ξ			G	IP-FP-B5	1.00				FILL OL	IT FORM 424 &	ATTACH	.05255	5	.065		
0099		3	3 01	l	25		1.00				FINAL \	/ISUAL INSPECT	TON	.137	.034	.171		41
00	10	N					1.00				FINAL \	VISUAL INSPECT	ION	.12700	)	. 158		
00	20	Ε			3.	:P-?W-R1	1.00								l	.012		
9000		39	01	ļ	25		.01				LARCR S	STANDARD HISTO	RY	.000	.000	.000		0
00	10							06JUN94	REMOVE UN	<b>NLOADING</b>	PAINT LINE	(OLD STD) .	57					
00	20							06SEP84	ADD STEPS	0005 ₺	0025 (OLD	STD> .55						
00	30							03DEC <b>94</b>	2 YEAR RE	ON/Walve	TIME CHANE	Œ						
09	00							N MONROE	/MANEAA									

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				LABO	r Stan	(DARD	OPERA	A RESOU	RCE STAN	DARD ANI	D METHOD	ANALYS	IS	12,00/88	A-E	)46B-MM1	L-DY- <b>H4</b> 5	PAGE	0001
	5592	Α				1A243					-G2			IN3-7-113			31050		
OPER TE	CH S	S	WFP	F A/	r rev														
~ 'B	T	K #	RAF	A SU	PPORT	CCC	<b>&lt;</b>			DESCRIP	TIGN			<del></del> >	BASE	PFO	STD		A
STI	PD	L	KCD	C ELI	EMENT	FACT		STOR	ED		SU	PPLEMEN	TAL		HOURS	TIME	HOURS	DLY	PCT C
PM153 9	Ε	YH E	A 5	J	88335	1.00	PERCEN	T ENGR 84	.5	MA	TCH UP W	HL KC13	5N		.13		.13		
0001		үн о	1 0	0		.00				PA!	RT NUMBE	R/NSN			.000	.000	.000		0
001	.0						211A24	3 <b>H</b>		1630005:	166758								
002	20						211A24	312		16300068	396014								
003	0						211A243	343		16300042	210319								
0010		C HY	1 2	1		1.00				WHE	EL MATC	H UP			.110	.023	.134		100
001	0 E		i	MGT-	E-24	1.00	BET EAS	BY AND PL	ACE EXAC	Ţ					.0009	77	.001		
002	:0 E			RWB-	JP-P7	1.00	UNPK PA	arts-bk ki	ey-snap	RING					.0823	7	.099		
003	0 N					1.00				MAT	CH WHEE	_ HALFS	2 F	ALFS	.0170	Ю	.020		
004	10 E		ŀ	RJP-I	W-R!	1.00	REM RP	PAPRWRK	SIGN OF	F DOC					.0100	1	.012		
9000		YH 0:	1 2	1		.01				LA	OR STAN	DARD HIS	STORY	,	.000	.000	.000		0
001	0						06JUNB4	ADD SUB	OP 0001	&UNLCAI	) LINE(D	COTS OL	1.68	}					
002	9						06SEP94	ADD STE	PS 0012	£ 0013 ∢	COLD STD	1.76							
003	0						02DEC84	2 YEAR	REVIEW/N	O TIME (	HANGE								
003	51						3MAR86	CHANGED !	SKILL CO	DE FROM	YG TO Y	1							
003	2						NO TIME	CHANGE											
090	r)							KERRY CO	OP MANEA	A TECHN	73357								

RCC PRD NROP NR

? <u>M</u>	NP6P1	55924	PP1	51			ΙΔF	÷ΩR STΔN	naani	OPER. JON	RESOURCE	STANDARD	ΔND I	METHOD ANALYS	IS 1 o/	<b>00 A</b> _E^A	12_MM1	(-DY~ <del>14</del> 5	DACE	0001
Q	PER	15 TECH	592 S			<b>(C13</b>	<b>5</b> N			น					_	13		310 <b>50</b>	rHOC	0001
	TUB	STEP						SUPPORT LEMENT		<b>\</b>	STORED	DESC	RIPTI	CNSUPPLEMEN	) T <b>al</b>		PFD TIME	STD HOURS	DLY	A PCT C
P	P151 000			 3S 3S	_			88335	.00	PERCENT EI 211A244 211A244-1 211A244-2 211A244-3		N.S. N.S. N.S.	PART L. L.	T WHIL HILF O/B NUMBER/NSN 7813	KC135N	.33	.000	.000		0
		0010 0020 0030 0040 0050 0060	BEBEER				GIG RWB RWB RWB		1.00 4.00 1.00 1.00 1.00 1.00	INST NONTH MASK & UNIT HANG WHL H PNT WHL HA PNT WHL HA	HREADED PL MASK MEDIL MLF ON PAI MLF-ZINC ( MLF (2ND ) MPRWRK SIE	LSTC PLUG IM PART (NT CONVYI DIFFOMATE COAT) SN CFF DOO	PAINT	7 WHEEL 2 COATS		.267 .00093 .01242 .02336 .11574 .10214		.334 .004 .015 .029 .144 .127	4.0	100
	9000	) 0010		SS	01	2	5		.01					r standard his (NE <old std=""></old>		.000	.000	.000		0

065EP84 ADD STEPS 0005 & 0025 (OLD STD) .55

03DECB4 2 YEAR REVIEW/NO TIME CHANGE

N MONROE/MANEAA

TO INTERROGATE LABOR STANDARDS, INPUT

PRD NROP NR

0020

0030

0900

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CPER		592	ΔA		(C13	5 N 🚧	£ 21						HOD ANALYSIS				PAGE	0001
27179		7	K	#R	A F		PORT						SUPPLEMENTAL		PFD TIME	STD HCURS	DLY	A PCT C
			35 35		<b>5</b>		333	.00	PERCENT EI 211A245 211A245-1		NSL	PART NU	HL HLF I/B KC MBER/NSN 4		.000	.33		0
0270	0010 0020 0030 0040 0050 0060	пшшшш		•	6 6 8 8	5 6FL-PA 616-SF 6WB-CH 6WB-SC 6WB-SC 8WB-SC	N-01 P-M1 I-WI C-02 C-P3	1.00 4.00 1.00 1.00 1.00	INST NONTH MASK & UNIT HANG WHL H PNT WHL H PNT WHL H REM RPL PA	READED PLASK MEDIC LE ON PAI LE-ZINC ( NLF-ZINC (	LSTC PLUG UN PART INT CONVYI CHROMATE CDAT)	PAINT W	HEEL	.267 .00093 .01242 .02336 .11574 .10214		.334 .004 .015 .029 .144 .127	4.0	100
9000	0010 0020 0030 0900		3S	01	25	5				emove unlo DD steps ( Year rev)	DADING PA	INT LINE 25 (OLD		.000	.000	.000		0

RCC PRD NROP NR  $\langle -- \times -- \times -- \rangle$ 

OP SR	151 TECH			k	C1	35	N	HL 2	211														12, v6. 4W3-7-				6 <b>8-1941</b> 8	-DY-M 1050	15	PAGE	00
911	STEP	T D	X L	#R K	A I	FA DC	SU EL	PORT	T	FACT	<		,	STORE	ED	D	ESCR	IPTI	CN	SUPP	LEMEN	TAL		>	BASE HOURS	1	PFD TIME	STD HOUR	3	DLY	PCT
PS151 0001	S	Ε	ΥH	EΑ	5		J	8335		1.00	PERC	ent Ent	ENG	R 99.	.9			PREI	VSP&/	ASSY	WHL !			 !	.69				9		0
	0010 0020 0030										211A 211A 211A	7 <b>44</b> -	. 1			N	.S.L .S.L .S.L	•													
	0040										211A	244-	3			1	6300	12427	7913												
	0010	Ε				RW	B-(	C-03		.00	IMPR	GNA	TE 1	4ED 9	SIZEI	) 操任	1				HEEL H	HAL:	:		.215	63		. 2	60	.7	39
0260	0020		YН	01	2	21				.00	REM I						l	PREIN			N WHEE	1. 1	IALF		.010 .015		.003	.(	12 19 05		3
	0020	٤				KA	L-(	C-46	)	.00	INSPI	CT	VISL	JAL											.001	15		.0	01		
0265		1	<b>7</b> H	01	2	1				.00							i	RACE				W-IL	/HALF		.178	38	.037	.2	16		31
0280		1	ſΉ	01	- 2	1			1	.00	REM !						I	BALAN	CE N	HEE	. HALF				.010	01 70	.023	.1	12 34		19
		Ε				GM	I	T-D1	1	.00	REMON	EM	ASKI	ing t	TAPE										.003	91			16 02		
	0040 0050	Ε				RW)	8-E	B-01	1	.00	BALA!	ICE I	WHEE PAPR	i ha Nwrk	LF SIGN	l CFF	DOC								.077	34 01		.0			
		Ε				RW!	3-4	W-91	1	.00	INSTI INSTI	. BE	ARNO	3/SNA	AP RN	IG SE	URD		LL S	EALS	& RE	TAI	NERS		.041 .024!	59		.0	29		7
1	0030	Ε,	<b>л</b> 1	^•	_	RJ:	)-F	₩ <del>-</del> R1	1	.00	REM F	PL F	PAPR	WRK	SIGN	CFF	DOC	4700	CTA	NDAR		TOR	Y		.0100	)1		.0	12		0
( (	0010 0020 0030 0031 0032	·	••	- •	-	-				- ·		84 / 84 / 84 / 6 Ct	ADD ADD ANG	SUB STEP AR R ED S	CP 0 S 00 EVIE KILL	001 8 12 & W/NO CODE	UNLO 0013 TIME FRO	AD L CHA	INE ( D ST NGE TO	OLD D> 1 YH	STD> .76				. 444		• • • •	••	••		ŭ

RCC PRD NROP NR  $\langle --- \times --- \times --- \rangle$ 

15592A KE	LABOR STANDARD OPERATION RESOURCE S'	STANDARD AND METHOD ANALYSIS 12.06/88	A-E046B-HM	1 <b>-DY-<del>114</del>5</b> 81050	PAGE 0001
	F PF A/R REV A FA SUPPORT OCC < C DC ELEMENT FACT STORED			std Hou <b>rs</b>	
0001 YH 01 0010	5 J 88335 1.00 PERCENT ENGR 99.9 00 .00 211A245 211A245-1	PART NUMBER/NSN NSL	.000 .000	.000	0
0180 YH 01	21 1.00 RWB-EC-03 1.00 IMPREGNATE MED SIZED	IMPREGNATE WHEEL HALF	.21563	.260	.7 39
0260 YH 01 0010 E	21 1.00 RWB-JP-W2 1.00 PREP TO ASSY OR DISS' KAL-6C-46 1.00 INSPECT VISUAL RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN	PREINSFECTION WHEEL HALF Y WHEEL	.00442	.005	3
0265 YH 01 0010 E 0020 E	21 1.00 RWB-BC-03 1.00 INSTALL BEARING CUPS RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN	RACE INSTALLATION WHIL/HALF	.178 .037 .16838 .01001	.216 .203 .012	31
0280 YH 01 0010 E 0020 E 0030 E 0040 E 0050 E	21 1.00  GPL-PD-01 4.00 REM NONTHREADED PLAS' GMC-MT-D1 1.00 REMOVE MASKING TAPE RWB-DH-W2 1.00 REMV WHL HLF F/PAINT RWB-BB-01 1.00 BALANCE WHEEL HALF RJP-FW-R1 1.00 REM RPL PAPRWRK SIGN	BALANCE WHEEL HALF STIC PLUG CONVYOR OFF DOC	.111 .023 .00339 .00191 .00833 .07734 .01001	.134 .016 .002 .010 .093 .012	19
0282 YH 01 0010 E 0020 E	21 1.00 RWB-AW-B1 1.00 INSTL BEARNG/SNAP RNN RWB-AW-C1 1.00 INSTL TIRE CHANGE DA' RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN	INSTALL SCALS & RETAINERS  G SECURD  TA PLATE	.041 .009 .02459 .00692 .01001	.029	7
0010	21 .01 06JUN84 ADD SUB GP 00 06SEP84 ADD STEPS 00: 03DEC84 2 YEAR REVIEW	001 &LNLDAD LINE(DLD STD> 1.68	.000 .000	.000	0

3MAR86 CHANGED SKILL CODE FROM YG TO YH

KERRY COOP MANEAA TECHN 73357

NO TIME CHANGE

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  $\langle --- \times --- \times --- \rangle$ 

0031 0032

0900

	155 TECH	92A S S		KC13					STANDARD AND ME RCC MNPGW						PAGE	9291
	STEP	TK	#8 K	A FA	A SUPPORT				DESCRIFTION					HOURS		PCT C
#C391 3391	S	E KI KI	EA Ø1	5	J 88335	.00	211A243M 211A243M2		CLEAN I PART NI 163000516675 163000689601 163000421033	UMBER/NSN 58 14		1.75		1.75		ž.
2007	7	ΚI	31	27	7	1.00			CHEM CL IER CLEAN 2EA HAL	EAN WHEEL (MAG)	)	. 424 . 21288	.114	.538 .538		71
2209	9 9019 9029	KI E N	Ø1	27 F	7 RPL-53-M2 71 G-CL-M1	1.00	SANDBLAST	MED PART DAD CARRI	BLAST ( WALK-IN B IER CLEAN SN OFF DOC	CLEAN WHEEL MEI	D	.217 .1 <b>9</b> 189 .21269	.059	.277 .129 .134 .012		15
3913	3	ΚI	31	27	7	1.30			CHEM CL IER CLEAN 25A HAL	EAN WHEEL (MAG)	)	. 424	.114	.538 .538		31
	7 9919				7 RPL-58-L2				ELAST C RT - HOISTOLASS E					. 403 . 402		23
	8 0010 0029 0900	ΚI	Ø1	27	•	. #1	Ø3DEC84 2 18JUL85 MC D.PARKER 1	YSAR REVI OVED N&B 1 ECHN MANE	LABOR S TEW/NO TIME CHANG TO HB SKL (TM WAS G <b>AA</b>	STD HISTORY SE 1.47		. 260	. છે <u>છે</u>	.000		ğ

RCC PRD NRJP NR <--->---> 1234567890123456 ELSE PUT IN END

6-May-8

STL=STEEL
AL=ALUNUM
MAG=MAGNESTUM
TITA=TITANTUM
SS=S STL
SYM=SYNTHETIC
LD=LEAD

B52 MLG WHEEL ASSEMBLY

BILL OF MATERIALS

69595A

## = SHOP # = MMI

TITEL TOTAL	- Julie	CHICAL TA	O DOM IN	200	. 300	6	PER I DE 16ATE (EAPTING) TVPE (PRINCIPUE)	FACTOR	TVPC (CORE	END II	CONTROL	2	101	PER OF GATE (EATTOR) TYPE (CIDE) FUEL CONTROL   CAS   103   252	0FT0 22
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		300-754-1	1000077100011	3 5	INTELL MOSERABLY	: :	 5 g		<b>-</b> -	 					
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		N.Y.L.	. N. S. L.		in which has bushest, including	: :									
	2:::	.N.P.L.	.W.S.L.		BESTING & CIP ROSY (PSEUDO)	æ ′	 i								
	<b>*</b>	63831152-33	11630009311012	198747	:BUSHING, BEARING BORE (RPR)	===	 55								
	<b>*</b>	167324	3110005543196	B. 003	:CUP, BEARING	Ξ	<u></u>		<b></b>						
••	3	N.P.L.	. N. S. L.		: BUSHING & CUP ASSEMBLY (PSEUDO)	æ ₩				<u></u>					
		191-338-1	15365001947078	23382	BUSHING, BRG & LCK RNG (RPR)	=	- <b>5</b>								
	_	167324	:3110005543196	1,6003B	CUP. BEARING	=	:EA ::								
		658X2392-01	3120000139128	98747	BOLT HOLE RPR/1ST	05:27 AR	A3:55								
		215-100X7999	. S. L.	:98747	TIE BOLT HOLE RPR/2ND	05:27 #8:	·			1					
	• •	65BX2394-01	131200010197111.5		TIE BOLT HOLE RPR		98:EA :			4		<u> </u>			
		8/773	31200040248451 F				ARIEA		. <b>.</b> .	1					
		65872395-03	13120011002679		DRIVE KEY INDEX HOLE		38:EA		•••						
		855926-01	. K.S. I.	100 166	DRIVE KEY INDEX HOLE	RPR:9 AR	A8:E4		. <b>-</b> -	- T-		<b>‡</b>			
		R55926-03	3120012664214	198747	DRIVE KEY INDEX HOLE	_	AR:EA		·	7					
. <b>.</b> .	•	45RT7393-01	712000840354	198747	KFV BOILT HOLF RPR		<b>1</b>			 i					
		157796	312000734110F		BICHTIME KEY BOLT HOLE BP8	9	96:FA ::		- <del>-</del> -	3					
		10-1061-1	.N.S.I.		C. MEET HOLF. MROARD	: =	·			·		. <b>.</b>			
. E		67724	13110005543196	82.007	17. PF. PF. PF. PF. PF. PF. PF. PF. PF. PF	<b>3</b>	100 EPA ::		·	· •					
15:		R54-146	5310000121026	197153	RETAINER FELL INNER	! : ==									
N.S.		E50024-141	5330001804694	25472	FELT, PERFORMED	: =	 55			·					
STL		1856-147	:5330007576409	197153	:RETAINER, FEL., OUTER	Ξ	 55								
:ST	12	185-170	5365006145517	125472	ILOCK RING	=	 55								
ist		109533	:5365001823259	55284	:LOCK RING	≂	 55			9		<u> </u>			
_	_	IME21042-5	15310008071467	906961	INUT, SELF-LOCY:NG	ž	 <b>5</b>	_							
	-	:80-28¢	:5310010551954	197153	:IMSHER, 30 DEL REES	æ	<u></u>								•
	2	: MM960-10L	15310006559800	188044	:WASHER, FLAT	æ	 \$3								
	:2	HS25191-279	2302009597686	90696:	1 BOLT, BALANCE IT	Æ	<b>2</b>								
เรา	2	:97-T3	11630000556302	197153	:NEIGHT, MHEEL 34L 1.00 0Z	<u>æ</u>	 								
isi	2	08-76	11630001257170	197153	:MEIGHT, MMEEL 30L 0.50 02	æ	 55			<u>4</u>					
ist	12	197-107	N.S.L.	156878	:NEIGHT, NHEEL BAL 0.25 02	æ				  -					
	::1	1-92-981	11630011112990	25472	:. MEEL HALF ASSY, OUTBOARD	==									
	:2	W.P.L.	:N.S.L.		WHEEL HALF SUBASSY OUTBOARD	==									
	۲۰۰۰	1N.P.L.	.N.S.L.		BUSHING & CUP ASSY (PSEUDO)	æ									
	7	07-25112079	11630009311012	198747	BUSHING BEARING BORE (RPR)	=	, EA								
	-	\$27.24	3110005543196	82009	C. C.P. BEARING	: =	Α.		·						
	r	N.S.L.	.N.S.L.		BUSHING & CUP ASSY (PSEUDO)	<b>3</b>	·	• • •	·	4					
	•	1-62-161:	1630007678199	22382	BESHING ROG L (CK RNG (RPR)	: =	.FA :								
		67724	3110005543196	82009	CIP. BEARING	: =			. <del>-</del> -	· -·		. <u>.</u> .			- <u>-</u> .
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16-May-89

STL=STEEL
AL=ALUNIMUN
NG=NAGNESILN
TITA=TITANIL™
SS=S STL
SYN=SYNTHETIC
LD=EAD

B52 MLG WHEEL ASSEMBLY

BILL OF MATERIALS

A29594

** = SHOP * = MMI

: ROUTED	CON LEVEL:	L: PART	: STOCK	VENDOR	HOMENCLATURE	:UNITS:UN	IT:YIELD	SCRAP :PA	RT :MIC :	REV 1EF	UNITS:UNIT:YIELD:SCRAP :PART :MIC : REV :EFFECTIVITY:TECH DRD	RD : PENDING	: PENDING : PENDING	: PENDING	
<u> </u>		NUMBER	NAGGR	3000		 	F :RATE	FACTOR: TY	PER 1 OF 1RATE 1FACTOR(TYPE 1000E1LEVEL)		CONTROL : CNG	: 103	ZZ 	: AFT0 22	
						HSSV :HE	HEAS:	ar.	R,D,C:		DATE : NUMBER	R : ACT10N	: ACTION	: ACTION	
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15.	7 .	0/1-09:	3363006143317	2472	:LOCX RING	 E			 					••	
	7	10%22	12265001823259	200	:LOCK RING	<u>5</u>			 .:	 83	<u>.</u>				
		:MS21042-3	:5310008071467	90696:	INUT, SELF-LOCKING	;2 (EA									
	12	: MM60-10	5310001670818	14088	E-EXPERT	12					••			•	
	2	: MSX5191-276	15305009847343	90696	SCHEM. COUNTER	12 154						•			
	2	2944-794-			PLATE TIRE CHANGE COUNT	2 !									· •
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	•	TAMES ASS.	120100013B002	9000	Control of the Control of Assertan										
<b>-</b> .	7	07-510-610-61	149CICIONENCE!	1000	SCACE, THEY, PLAINED	<u> </u>		-	. <u>.</u>			· <b>-</b>			
	2	:FSZ1042-3	15310008071467	90696	:NUT, SELF-LOCKING	æ. ₩.									
	2	: AMP60-10L	12310006359800	77088	: INSHER, FLAT	<u>₹</u>						•-			
	2	HS35191-279	5305009592689	90696	BOLT. BALANCE INT	1.00									
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	2	:47-107	N.S.L.			 Æ	••		<u>≪</u> 	 _					
	<b>-:</b> :	TR/25-03	12640000218295	7993	:.VALVE ASBENDLY (STD)	<u>ង</u>								_	_
	:2	23.FE	:N.S.L.	179934	:. CAP, WALVE	===							••		
	:2	-TR-C4	12640008105861	79934	CORE, WALVE	 23:									
Ę	2	IRON:	. K. S. L.	79934	STEN. WALVE	: =:									
į		TR-PETO			(CLS) (STD)	: =		. <u>.</u> .						. <b>.</b>	. <del>-</del> -
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į E	<u>.</u> :	- 054/2011 - 105/2011	12.00 L	2004	i.vM.V. Haar (Int G. J.)	5.			Ξ.	 ⊋					. <b>-</b> -
	7	3	.N. 5.L.	***/:	in the water	 ==									
	2	\$ #:	12640008105861	79934	:COPE, WALVE	<u> </u>						••			<del>-</del> -
	7.	MS27436	.X.S.L.		I. STEM, WALVE										
	2	F59068-11	2220000712204	90696	:O-RING (1ST 0.5.)	.: 83			<del>-</del> -		•••				
	<b>:</b>	:TR749-03	12640008013117	7,007	:.VALVE ASSY (2ND D.S.)	11 48:54			<u></u>	 PLT					
	2	13 A E	:N.S.L.	79934	1 CAP, WALVE	==									
	2	\$ #:	:2640008105861	17934	: COPE, WLVE	1: 43:									
	2	: TR749	IN.S.L.		:STEM, WALVE	==					••				
	2	:RF-13	:5330008181675	179934	10-RING (2ND 0.S.)	±						••			
••	=	:NS28889-2	: 4820005356483	90696:	:.VALVE ASSY (370 0.S.)	11 AR:ES		•		 F1					
	!2	23.4E	:N.S.L.	17997	i CAP, WALVE	==					••				
	:2	34 <u>C</u>	12640008105861	179934	: CORE, VALVE	11 154					•	••			
•••	:2	:HS28889	:N.S.L.		:STEN, WALVE										
	:2	:NS28775-015	15330006185361	90696	0-RING (3R0 0.S.)	11.		• •				•-			
Ę	=	149-148	11630006862275	:97153	THERMAL PLUG, RELIEF	13									
	::	HS28775-012	:5330005840265	90696	PACKING. O-RING	13									
Ŕ	==	163-214	5310008062358	25176	.N.T. SELF-LOCKING	177					- <del>-</del> ·				
Ĕ		180-788	1531000019663	197153						•					
Ę	:	147-500	1204009615041	25170	BOLT 12 POINT	_					<b>-</b> -	<u>.</u> -		_ ~	
	-	16.64	311724070007727		D-BING, FOSCET	5 43: 1:									
Ę	: -:	1502-00	1277090000135			5.5				- <b>-</b>		<u>.</u> -			-
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26

STL-STEEL
AL-ALLINUM
NOS-WOBESTUM
TITA-TITA-TITANIUM
SS-S STL
STN-SWINETIC
LD-LEAD

BS2 MLG WHEEL ASSEMBLY

BILL OF MATERIALS

A2959

44 = SHOP 4 = PMI

ROUTED	LOW LEVEL:	PART NUMBER	STOCK I NURBER	- VENDOR	NOMENCLATURE	(UNITS:UNIT:YIELD:SOCRAP :PART :NIC : NEV :EFFECTIVITY:TECH ORD : PENDING : PENDING :	SONA : PAR	THIC HEV	EFFECTIVITY:	TECH ORD	PENDING	FENDING	PENDING
						ASSY INEAS:	. R.D.	ü	DATE	NUBER.	ACT 10N	ACTION	ACTION :
	. :	IN.P.L.	:X.S.L.		: DRIVE KEY & SPACER (PSEUDO)	9 <del>4</del>	<u>.</u>						
Ĕ	:2	149271	:1630007677649		DRIVE, KEY	11 EA :			- <u>-</u> -		_		
ξį	:2	:66032462	in.S.L.	~-	SPACER, DRIVE KEY				· ••		. •		
ន		172-204	:6740001037035	•-	:. SHIELD, HEAT	55			•				• •
ន		1,650300-90-3	:N.S.L.		L'SHIELD, HEAT	11 96		975	• • •				·
<b>88</b>	-	104-00C359	:X.S.L.	198747	SHIELD, HEAT	 84 	••	875	•				• <u>-</u> .
ន		72-211	11630009453213		:.SHIELD, HEAT	11 AR155		900		•			
••		9-06002359	:N.S.L.		LOLIP, HEAT SHIELD, MODI	136				•	•		

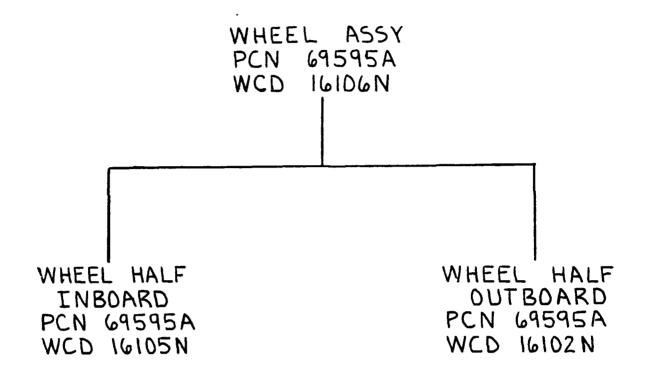
16-May-89

64 <u>024-T</u>	*L7717		C # 30 *	_ 3 1 J		W 10,4		4:38 PM	
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## CONTROL NUMBER LIST

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DELE		69568A	C-430 NL	PISTONEY	162 <del>9-50-754-8008</del> .2	. 25. NEV. 86	462-23-I	<u>.</u>
JENT.	POLL	89569A - €-3	C-130 1L		16 <b>25-00-005-0055</b> -1	30060431	481-89:455	35
DELE	•	69572A	C-1367 FL		162 <del>9-99-623-8917</del> -1	25-109 86	451-37-3	**
COOP	POLL	69573A	C-130 ML6	TORQUE STRUT	162 <del>9-69-</del> 623 <del>-89</del> 13	389 <b>645-</b> 7	451- <del>67-</del> 13	
BENT	POLL	69577A	C-130 NL		162 <del>8-86-</del> 976-3391	3716 <del>87-</del> 12	45A6-7-\$	35
DENT	POLL		C-136 NL	<del>-</del> -	1626-61-143-1195	7926487-36	452-25-3-*	<b>65</b> ~
JENS	PRIC	69589A -J	F-199 NL		163 <del>8-68-6</del> 67-4924	3-1686	4H3-7-1923 ^	30
JENS	PRIC	69591A -J	F-166 NL		163 <del>8-88-</del> 696-3 <b>57</b> 8	218A381	4N3-7-1293	35
RI69	PRIC	69595A/	B-52		1636-86-212-9742	3-1192-1 A	481-4-133	<b>A</b>
DELE	11120	696 <b>02</b> A	F-166	BONE SWITCH	144 <del>8-88</del> -942-1847AA	11 JULY 86	11L1-3-14-3	£
COVI	SHEL	696Ø3A	F-111 -	INERTIA REEL	1377-61-141-8911	Ø193157-77	11P <del>9-</del> 11-3	<b>#</b>
MART	SHEL	69621A	A-37		1 <i>98</i> 5- <i>99-9</i> 51-8784	DCX-144A378-9	11W1-15-12-2	*
BENT		69626A	C-130 NL		162 <del>9-88</del> -585-11 <b>94</b>	3383571-3-1:	452-23-3	85
BENT		69651A	C-136 ML		162 <b>9-06</b> -623-8911	37 <b>6438-</b> 1	4S1-37-3	
BENT		69652A	C-136 HL		162 <del>9-99-</del> 111-1418	695 <b>661-9A</b>	4S1-37-3	<b>56</b>
BENT	POLL	69653A	C-136 NL		162 <del>8-00-</del> 697 <b>-0</b> 191	3526 <b>64</b> =	_	<b>5</b>
	RIGB					5993863-6	452-23-3	<b>5</b>
JENS		69654A -G-J	·	BRAKE ASSY	1638-91-118-3642		4B1-2-1163	36
JENS	POLL	69655A -6-J		BALLSCREN	1629-91-965-4867	843012	1663-2-87-3	26
BENT	COOP	69657A√	KC-122 HT		162 <b>9-9</b> 1- <b>9</b> 38-91 <b>9</b> 2	7531273-96	4\$1-5 <del>6-3</del> 3	55
BENT	COOP	69658A	KC-135 HL		162 <del>9-0</del> 1-038-9161	7531273-166	451-56-3	55
DELLE		69697 <b>J</b>	C-141 HL		162 <del>9 59</del> 292-5315	2 JAN 85	4S1-73-3	
	700P	697 <b>97A</b>	F-15 ±M		162 <del>6-86</del> -365-1 <del>963</del>	68 <b>4458</b> 771-1 <b>96</b> 1	452-73-4	3
		6977 <b>5</b> A -6	C-141 . M.		5315 <del>-80-500-400</del> 1LE		451-23-35:	25
COUr	TOLH	69777A	B-52' HL		162 <del>9-98-</del> 217-4961	1 <del>-0665</del> 4 °	4S1-2 <del>9-</del> 4	25
JEN6	PRIC	69794A -J	F-15 HL	WEEL South Co.	16 <b>39-61</b> -141 <b>-469</b> 5	5 <del>66</del> 6864-9	4W1 <del>-0-</del> 73	26
MENR	TOLM	698 <b>83A</b>	DH-3 NL	S STRUT ASSY	162 <b>5-9</b> 1- <b>288-9</b> 338	8341139-19	492-5 <del>8-</del> 3	42
JENS	RI68	698Ø7A -J	F-15 HL	6 A/B BRAKE ASSY	163 <del>8-9</del> 1 <del>-9</del> 18-2118	5669913-19	4B1-2-1123	23
MONER	ande	69825A	C-54 + ML	G UPPER BEARING	312 <del>8-88</del> -251-7338LE	7 <b>9869</b>	452-67-3	31
DELE		69826A	F-16 - ML	g drag strut-	16 <b>25-5</b> 1-1 <b>51-1798</b>	16 APR 86	4SA6-32-3	e de la perfection de la companya de la companya de la companya de la companya de la companya de la companya d
COOP	TOLH	69833A	F-111 HL	STRUT ASSY-SHOCK HN	1626-61-163-1956	1136166-563	451-87-3	22
BELE	e ar	6983 <del>4A</del>	F-16 ML	DRAG STRUT	16 <b>28-81-678-9368</b>	26NNR 86 77F	45A6-32-3	<b>₹</b>
DELE		69853A	B-52	BOX END CROSSOVER	1 <i>98</i> 5 <b>-66</b> -898-9671	28 OCT 86	11F8-3-7-3	
COOP	TOLM	69 <b>855A/</b> -6	B-52 ML		162 <del>9-99-495-</del> 2748	5 <del>-68</del> 457-5	4S1-57-3	36
HART		69857A	A-15	EDWALIZER GAU-8	1995-41-455-4315	295F489	1141-7-14-3	<b>2</b> 6
DELE		69865A	A-19	DRUM ASSY GAU-8	1995-91-993-1436	<b>95-28-8</b> 7	11W1-7-14-3	
DELE		69873A -J	C-47 HL		163 <del>8-88-959-285</del> 2	25 NOV 86	4B1-5-23	•
DEL€	£	69875A	E-201 ML		1625-61-663-1412	16 (OCT-48)	444-15-31-2	<b>3</b>
COOP	TOLH	69887A	B-52 11		1625-55-755-7261	5-96453-501	456-2-312C	72
MONR	ANDE	698 <b>98A</b>	C-5A NL		1629-69-115-7433	4651437-1 <i>0</i> 7A	452-67-3	36
MONR	ANDE	69899A	C-5A NL		312 <del>9-98-</del> 158-1799LE		452-67-3	36
DELE	FEEL		B-52		1965-99-213225	28 OCT 86	1181-34-3-1	
DELE		6991 <b>5A</b> 699 <b>29A</b> =		AMMO CAN		25 ULT 65 25 FEB 87**	452 <del>-26-3</del>	g g
	TOLM		E-16 NL		162 <b>9-81-878-</b> 27 <b>47</b>	121.9548-13	444-15-3	<b>S</b>
CALD		71 <b>669A</b>	F-111 ML		1626-66-415-6296			· ·
DELE		72827A	C-5A ML		1628-08-887-6835	12:DECEMBER 86	451 <del>-94-</del> 31-3	•.
DELE		72836A	C-5A ML		162 <del>9-99-</del> 115-7387	5-0CT-87	4S1-93-3	7 17
DELE		72846A -6	C-5A ML		1628-88-115-2817	12:0ECEPBER 86	451-93-3-1-15	
ADIA.	MOE	72848A	C-SA NL			163.0432-161A	452-67-37-72	.29
	DE	72852A	C-5A ML		162 <del>9-66</del> -116-2 <b>979</b>	4612 <b>466</b> -1 <b>5</b> 1A	451-93-3	14
TIC.	.€E	72877A -6	C-5A NL		M 162 <del>5-66-</del> 432-5651	4651463-1636	452-67-3	46
MONR	ANDE	72879A	C-5A ML	6 OUTER CYLINDER	n 162 <del>0-00-</del> 446-3776	4611415-1 <b>67</b> A	4S1- <del>9</del> 3-3	

## B-52 MAIN WHEEL



WCD 16106N PCN 69595A 88245

> IN Induct Indo System

LOAD Onto Conveyor/workbench

1B Disassemble Wheel halves

WED 16102N 88281 WCD 16105N 88281

Remove bearing race from wheel half Remove bearing race from wheel half

Load onto chem Clean Line Load onto chem Clean Line

7A Cleaning Process 7A Cleaning Process 7B Unload from Cleaning Line

> 9 Blast wheel half

10 Romove Bearing Bore bushing (15 Required)

Blast bearing Bore bushing area (IC removed)

LOAD onto Anodize strip Line

12A Anodize Strip

15/15A Flouresent Particle Inspect 7B unload from Cleaning Line

Blaot wheel half

Remove Druc Key bushings (If Required)

Remove bearing wore bushing (If Reg)

Blast bearing bore bushing area (If Removed)

LOAD onto Anodize Strip Line

Anodize Strip

Unload from FPI line

Mick and Burr

40 E and I Inspection

machine wheel half making Surface

repair Value Stam hole (if leguired)

The bolt hole repaire (12 Reg.)

Pre Inspect Ocan

FPI Inspect

15B Unload from FPI Line

19 Nick and Burr

Earl I Inspection

50 Fusc Plug hole repair

machine wheel half mating Surface

70 Repair he bolt hole Boss face

80 Repair Tre bolt hole 95A FPI. Impedion

Pre Inspection Clean

150 Bearing Bone Seal repair (if Reg)

FPI Inspect

Bearing bore repair (IS Reg)

87 Bearing bonc Seat repair

Bearing bore lock Ring Groot Repair (If Reg) 90 Bearing bore repair

Cracked wheel Weight holz repair (If Rag.) Machine Key bolt holes

210 Cracked time counter Note repair (IS Reg.) machine drive Key index holes

120 Pre-Inspect Clean Machine wheel ID Koyseal Area 220A FPI Impection

225 Clean wheel Nalf

5hof Peen

A, B, C, D, E, F G, H, I, J, K Anodize process

250 Indall tie bolt bushing

also Install Cup Into bearing bore bushing

Machine od of bushing & cup Assy 140 repair bearing bore lock ring Groove.

150 Repair Cracked Wheel weight hole

155 Repair cracked time counter hole

Prc Inspect Clean

160A FPI Inspection

clean wheel half

180 Shot Peen wheel Valf Install lawhing and cup Hosy into bearing bore

Install cup into bearing bore lock ring bushing

Machine 0.0. of bushing and cup Assy

Install bushing and cup Asay Into bearing bore.

330 Install thread (neerts

Inoped, check paperwork and hood on oven conveyor 190 A,B,C,D,E,F G,H,I,J,K Anodiza Process Type II Class I

Install the bolt bushing

204 Install cup In locaring bore bushing

Machine OD of bushing and cup Assy

Install Bushing and Cup Harry 18to bearing bore

Install cup into bearing bore lock ring bushing

Heat wheel halves in

Install bearing race in wheel half

move part to unloading conveyor

360 LOAD Paint Line

360A Trichloroethane wash wheel half

360B MASK AS Reg.

Prime wheel hall

Machine 00 of bushing of Cup Assay

Install Bushing & ...

Gup Assy into bearing bore

machine Key bolt hole bushing

Install Key bolf hule bushing

machine drive Key Index hole bushing

Install Drive Key index hole bushing

Move, check paperwork
Load onto bearing oven
Conveyore

Mandaday Dry time

Of Coat Paint

2nd Coast Paint

mandatory dry time

> 360 H Strip Masking and plug's

unload from paint line

380 (390,400)
Assemble Seels,
Check paperwork
Inspect.

Heat wheel half

275A
Install bearing
race into wheel
half

275B unload onto Conveyor that feeds Paint line

Load paint line

280A trichloroethane WASh

280B MASK & Plug

280C Prime whoel halves

Mondalory Dry Time

1st Coat Paint

and coat paint

Maminum dry time

280 H femour masking and flugs

280 I LOAD onto wheel balance Conveyor

> 290 Balance

295 Assomble seals Check paper work Visual Inspection WCD IGIOCN

March-up

Assembly

Touch up paint

997 Final paperwork Check

998 Final Yisual Inspection

> 9999 SELL

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·		THE BASIC TECHNICAL ORDER (1.0.) AN T.O. SUPPLEMENTS REFERENCED. THE	!						
		APPLICABLE T.O.'S AND SUPPLIADARD WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THIRD HEY							
		CLEANED & PROTECTSD (UZE MOVE) FOR MOVES BETWEEN OPERATIONS/ULSPATCH STATIONS.							
		WARRING MANY OF THE FOLLOWING CERAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES : CHECALS							
		WHICH ARE POIENTIALLY DAMESHOUS FO PERSONNEL. ADEQUATE BATEGORIDS AMD PRECUATIONS MUST BE LITED TO PRECUDE INJURIES.							
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. PART NU	MBER	8	TECH DATA				9. ITEM SER	IAL NO.
MODEL-I	DESIGN-SERIES	II STOCK NUME	BER	12 OPTION	AL .			
3. SERIAL	NUMBER	14 NOUN 4/4/1/1/1/1/1/199	LF INBOARD					
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. PART NU	MBER	[8	TECH DATA			9. ITEM SER	IAL NO.
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S. DISPATCH	16. PERF RCC	17. OP	WORK TO BE ACCOMPLISHED		18.	19. p	20.
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MODEL-C	DESIGN-SE	RIES II STOCK NUMB	ER 12	OPTIONAL		<u> </u>	
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## SAME AS PCN 69595A

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001 RCC INPGN 4H1-7-1143 900-9739 81043 PER TECHSS WE PE A/R REV SUB T K #R A FA SUPPORT DCC <----- DESCRIPTION -----> BASE PFD STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C 5001 S N KI EA 5 J 88298 1.00 PERCENT ENGR 69.4 CLEAN WHEEL B-52 .92 .92 0001 KI 01 00 .00 PART NO. / N.S.N. .000 .000 .000 3~1192 1630009009739 0010 0020 3-1192-1 1630012286043 0007 KI 01 27 1.00 CHEM CLEAN WHEEL .116 .031 .147 0010 N ZLG-CL-M1 .50 LOAD & UNLOAD CARRIER CLEAN / .21200 .134 0020 E RJP-PH-R1 1.00 REN RPL PAPRWRK SIGN OFF DOC/ .01001 .012 0009 KI 01 27 1.00 BLAST CLEAN WHEEL LISE .432 .117 .550 59 RPL-SB-L2 1.00 SANDBLAST LARGE PART - HOIST 10 E در .31693 .402 0020 N ZLG-CL-H1 .50 LOAD & UNLOAD CARRIER CLEAN .21200 .134 0030 E RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC .01001 .012 0012 KI 01 27 .10 BLAST CLEAN WHEEL LISE .432 .012 .055 0010 E RPL-SB-L2 1.00 SANDBLAST LARGE PART - HOIST .31693 .402 ZLG-CL-M1 .50 LDAD & UNLOAD CARRIER CLEAN .21200 .134 0020 N 0030 E RJP-PN-R1 1.00 REM RPL PAPRNIRK SIGN OFF DOC .01001 .012 0013 KI 01 27 1.00 ANODIZE STRIP WHEEL ALUM .136 .037 .173 .7 19 0010 E ZCD-ST-S1 1.00 ANODIZE STRIP .12630 .160 RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC 0030 E .01001 .012 KI 01 27 .01 .000 .000 9000 LABOR STANDARD HISTORY .000 0010 28DEC84 2 YEAR REVIEW/NO TIME CHANGE 1020 CRIMAYRS DWN GRD TO N STD (TH WAS .76) 0021 18SEPTB6 2 YEAR REVIEW CHANGED OCC FACTOR STEP 0022 0010 SUROP 0010 BOTH WHEELS HUNG ON 1 CARRIER

0900

KERRY COOP MANEL TECHN 73357

3 INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192 RCC MNPGW 4W1-7-1143 900-9739 81043

ER.	TECH	s s	₩F	PF A/R REV								
SUB	!	тк	#R A	FA SUPPORT	000	<	DESCRIPTION>	BASE	PFD	STD		A
	STEP	DL	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY F	CT C
301	s	E HB	EA 5	J 88300	1.00	PERCENT ENGR 99.9	DISSY. WHEEL B-52 M.	1.52		1.52	<del></del>	
000	1	ΗВ	01	00	.00		PART NO. / N.S.N.	.000	.000	.000		0
	0010					3-1192	1630009009739					
	0020					3-1192-1	1630012286043					
000	5	ΗВ	01	25	1.00		DISASSEMBLE	.776	.194	.971		64
	0010	Ε		RWB-JP-W1	1.00	PREP TO DISASSEMBLE WH	EEL.		0	.020		
	0030	Ε		RWB-HT-C3	1.00	HANDLING TOOLS PER END	ITEM	.1383		.172		
	0040	Ε		RWB-DW-T1	27.00	REM UNORSTR WALL TIE BO	LT 27 EACH	.0105	6	.356		
	50	Ε		RWB-QW-K4	9.00	DIS WHL (REM MULTI SCN	B/K) 9 EACH	.0206	0	.231		
	0060	Ε		RWB-DW-C2	2.00	REM DATA PLATE & STAMP	WHL 2 EACH	.0306	7	.076		
	0070	Ε		RWB-DW-B1	2.00	REM BEARING (SNAP RING	SEC) 2 EACH	.0122	7	.030		
	0090	Ε		RWB-DW-M1	1.00	DIS WHL (V/L-L & M WHE	ELS)	.0426	5	.053		
	0100	ε		R₩B-D₩-H1	1.00	REM HEAT SHIELD (SINGL	E PC)	.0021	7	.002		
	0120	٤		RJP <del>-PW-</del> R1	1.00	REM RPL PAPRWRK SIGN O	FF DOC/	.0100	1	.012		
	0130	E		RLG-RS-K1	1.00		/REMOVE TIE BOLT BUSHINGS	.0109	9	.013		
000	6	ΗВ	01	25	1.00		REMOVE BEARING CUPS	.442	.111	.553	.3	36
	0010	Ε		RWB-BC-01	2.00	THUNCE BEARING CUPS		.1634	6	.408		
	0020	Ε		RWB-141-02	1.00	LOAD HOOK W/WHEELS F/C	LENING	.1053	2	.131		
	0030	E		RJP <del>-PW-R</del> 1	1.00	REN RPL, PAPRWRK SIGN OF	FF DOC	.0100	1	.012		
900	0	нв	01	25	.01		LAPOR SID HISTORY	.000	.000	.000		0
	0010					28MAR85 2 YEAR REVLEN P	NO CHING (OLD 1.01)					

O OBJUNES CHANGED SKL CODE NO TH CHNG

0030 ZSJUNSS ADDED NICK&BURR TH (TH WAS 1.01)

0031	20NOV85 TETED STEPS 0020,0115 SUPOP 0010 AND
0032	STEP 0030 SUBOP 0020 WORK NOT DONE IN HB SKILL
3	CODE (OLD STD 1.09)
0034	18SEPT86 2 YEAR REVIEW CHANGED NICK & BURR TIME
0035	<old .99="" std=""></old>
0036	1DEC86 ADADDED STEP 0130 METHODS CHANGE (OLD 1.74)
0900	KERRY COOP MANEAA TECHN 73357

## ] INTERROGATE LABOR STANDARDS, INPUT

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	15	139A	В	52 M	WHEEL.	3-1192		RCC	MNPSN	4W1-7-114	3 900-97	3 <b>9</b> 8	81043		
-IR	TECH	s s	W	F PF	A/R RE	٧									
SUB		T K	#R	A FA	SUPPOR'	r occ	<	DESC	RIPTION	·>	BASE	PFD	STD		A
	STEP	DL	K :	C DC	ELEMEN'	FACT	STORED		SUPPLEMENTAL		HOURS	TIME	HOURS	DLY	PCT C
102	Ε	N DI	EA :	5	J 88302	2 1.00	PERCENT ENGR 10.2		E&I WHEEL HALF 0.B. I	3-52 M.	.61		.61		
0001	l	DI	01	00	I	.00			PART NO. / N.S.N.		.000	.000	.000		0
	0010						300-255	N.S.	L <b>.</b>						
	0020						300-255-1	1630	011112770						
0019	,	DI	01	27		1.00			NICK & BURR WHEEL LOS	E/HALF	.333	.090	. 423		69
	0010	Ε		R	LG-RS-N	1.00	NICK & BURR PTS-CON	IST F/PPE	P		.0231	2	.029		
	0020	N				1.00			NICK & BURR WHEEL LOS	E/HALF	. 2998	7	.380		
	0030	Ε		R	JP-PW-R:	1.00	REM RPL PAPRWRK SIE	SN OFF DO	С		.0100	1	.012		
		DI	01	15		1.00			E & I AND ROUTE WHEEL	-	.167	.025	.193		31
	0010	N				1.00			E&I AND ROUTE WHEEL I	<del>i</del> ALF	.1491	9	.171		
	0020	Ε		R	MB-OH-W	2 1.00	REMV WHL HLF F/PAIN	IT CONVYO	R		.0083	3	.009		
	0030	Ε		R	JP <del>-PW-R</del> :	1.00	REM RPL PAPRHRK SIG	N OFF DO	c		.0100	1	.011		
9000	)	DI	01	15		.01			LABOR STANDARD HISTOR	RY	.000	.000	.000		0
	0010						MOVE NAB TO	E&I FROM	CLEAN						
	0020						26MAR85 2 YEAR REV.	NO CHNG	(OLD TH .83)						
	0021						20NOV85 DELETED STE	P 0040 W	ORK PERFORMED IN HB						
	0022						SKILL CODE (OLD STD	.83>							
	0023						19SEPT86 DELETED ST	EP 0010	WORK PERFORMED BY KI						
	0024						SKILL (OLD STD .40)	•							

KERRY COOP MANEL TECHN 73357

LAROR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E0468-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192 RCC MNPGN 4W1-7-1143 900-9739 81043 ER LECH S S W F PF A/R REV

				A/R REV	000	, ne	TOOD I DITTON				
SUB	IK	₽R	A FA	SUPPORT	UCU	( Dt	ESCRIPTION>	BASE	PFD	STD	İ
डाह	, D F	K	C DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT (
05 E	N D	EA	5	J 88301	1.00	PERCENT ENGR 10.2	E & I WHEEL HALF INSO.8-52M.	.61		.61	
0001	D	01	00		.00		PART NUMBER / N.S.N.	.000	.000	.000	0
0010	)					300-254 N.	S.L.				
0020	)					300-254-1 16	30011119667				
0019	ום	01	27		1.00		NICK & BURR WHEEL LGE/HALF	.333	.090	.423	69
0010	Ε		RL	_G-RS-NC	1.00	NICK & BURR PTS-CONST F/P	REP	.0231	2	.029	
0020	N				1.00		NICK & BURR WHEEL LIGE/HALF	. 2998	7	.380	
0030	Ε		R	IP <del>-PW-R</del> 1	1.00	REM RPL PAPRWRK SIGN OFF	DOC	.0100	1	.012	
	D.	01	15		1.00		E & I AND ROUTE WHEEL	.167	.025	.193	31
0010	N				1.00		ENI AND ROUTE WHEEL HALF	.1491	9	.171	
0020	Ε		Rt	/B-0H-W2	1.00	RENV WHL HLF F/PAINT CONV	YOR	.0083	3	.009	
0030	Ε		R	IP <del>-PW-R</del> 1	1.00	REM RPL PAPRWRK SIGN OFF	DOC	.0100	1	.011	
2000	D	01	15		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010						MOVE NAB TO EAT FR	OM CLEAN				
0020						26MARBS 2 YEAR REV.NO CHN	6 (OLD TM .83)				
0021						20NOV85 DELETED STEP 0040	WORK PERFORMED IN HB				
0022						SKILL CODE (OLD STD .83)					
0023						19SEPT86 DELETED STEP 001	O WORK PERFORMED BY KI				
0024						SKILL (OLD STD .40)					

KERRY COOP HANEL TECHN 73357

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHL 3-1192

RCC MNPNA

4W1-7-1143

ER	TECH	S	S	N F	PF	A/R REV									
SUB		T	K #	R A	FA	SUPPORT	000	<b>&lt;</b>	DESCR	RIPTION	<del></del> >	BASE	PFD	STD	A
	STEP	D	L	ς ε	DC	ELEMENT	FACT	STORED		Supplementa	L	HOURS	TIME	HOURS	DLY PCT C
102	s	E	DB E	A 2		J 88302	1.00	PERCENT ENGR 99.9		NDI WHEEL HALF 0.8.	B-52M.	.02		.02	
000	l		DB O	1	00		.00			PART NO. / N.S.M.		.000	.000	.000	0
	0010							300-255	N.S.L						
	0020	ı						300-255-1	16300	011112990					
009	5		DB 0	1	11		.05			FPI	16102N	. 181	.001	.010	50
	0010	Ε			Zl	.G <b>-ND-</b> 23	1.00	ZYGLO INSP LARGE PART	BLD507	<b>'</b> s		.17130	)	.190	
	0020	Ε			R	IP <del>-PW-R</del> 1	1.00	REM RPL PAPRWRK SIGN O	FF DOC	· · · · · · · · · · · · · · · · · · ·		.01001	l	.011	
022	)		DB 0	1	11		.05			FPI COUNTER HOLE	16102N	.181	.001	.010	50
	J-10	ε			ZL	. <b>G-ND-</b> 23	1.00	ZYGLO INSP LARGE PART	BLD507	<b>'</b> ,		.17130	)	.190	
	0020	Ε			R	JP <del>-PW-</del> R1	1.00	REM RPL PAPRWRK SIGN 0	FF DOC	,		.01001	1	.011	
900	)		DB 0	1	00		.01			LABOR STD HISTORY		.000	.000	.000	0
	0010	ı						20NOV85 REWROTE STD TO	MATC	1 958 (OLD STD .96)					
	0020	i						20MAY87-DELETED SUBOP	00 <b>85</b> 1	NOT DONE DLD STD	46				
	0900	ı						KERRY COOP MANE	aa tel	HN 73357					

10 INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

(---> ---> 123-7890123456 ELSE PUT IN END LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

15139A B52 M WHL 3-1192

rcc Inpna

4#1-7-1143

FER TECH S S N F PF A/R REV

SUB 1	K #RA	FA SUPPORT	OCC <-		DES	CRIPTION>	BASE	PFD	STD		A
STEP D	L KC	DC ELEMENT	FACT	STORED		SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT C
9105 S E	DB EA 2	J 88301	1.00 PE	RCENT ENGR 99.9		NDI WHEEL HALF INBD. 8-52M.	.01		.01		
0001	DB 01	00	.00			PART NO. / N.S.N.	.000	.000	.000		0
0010			30	0-254	N.S	.L.					
0020			20	0-254-1	1639	0010009667					
0085	DB 01	11	.05			FPI	.171	.001	.010	.8	50
0010 E		ZLG-ND-Z3	1.00 ZY	GLO INSP LARGE PAR	T BLD5	07	-1713	0	.190		
0160	DB 01	11	.05			FPI	.171	.001	.010	.8	50
0010 E		ZLG-ND-Z3	1.00 ZY	GLO INSP LARGE PAR	T BLD5	07	.17130	0	.190		
	DB 01	<b>∞</b>	.01			LABOR STD HISTORY	.000	.000	.000		0

0010 20NOV85 REWROTE STD TO MATCH 958 (OLD STD .96)

0020 20MAY87-DELETED SUBOP 0085 NOT DONE OLD STD .46

0900 KERRY COOP MANEAA TECHN 73357

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

⟨---X---X--->

1234567890123456 ELSE PUT IN END

	LABOR STANDARD			NDARD	OPERATI	UN RES	OURCE	STANDAR	D AND HETHOD	ANALYSIS	02/01/89	A-E04	6B-1911	-DY-H45	PAGE	0001					
	15	13	9♠		85									C MNPNA							
								'R REV													
Cin														CRIPTION			BASE	PFD	STD		٨
	STEP	D 	L	K	C	DC	El	EXENT	FACT		ST	ORED		SUI	PPLEMENTAL		HOURS	TIME	HOURS	DLY	PCT C
KNPNA	S	X	DB	EA	2		J	88298	1.00	PERCENT	ENGR	99.9		NDI WHEEL I	B-52M.		•64		.64		
0015	5		DB	01		11			.13	,				NDI TIE BO	LTS 1ST TI	ME	1.005	.014	.145		23
	0010	Ε				Z	LG-	-ND-H6	11.00	MAGNAGL	INSP	SHALL	OBJECT				.09138	;	1.115		
0020	)		DB	01		11			.13	•				NDI DRIVE	KEYS 1ST T	IHE	.822	.012	.119		18
	0010	E				Z	LG-	-ND-M6	9.00	MAGNAGL	) INSP	SHALL	ORJECT				.09138		.912		
2000	)		DB	01		00			.00	1				PART NO. /	N.S.N.		.000	.000	.000		0
	0010									300-254			N.S	L.							_
	0020									300-254	-1		1630	010009667							
	0030									300-255			N.S	L.							
	0040									300-255	-i		1630	011112990							
2001			DB	01		11			1.00					ZYGLO WHEEL	. LGE		.342	.038	.380	.7	59
	0010	Ε				Z	LG-	ND-Z3	2.00	ZYGLO II							.17130		,380		
9000			DB	01		00			.00					LABOR STANI	ARD HISTO	RY			.000		0
	0010									13 OCT.	B8 INI	TIAL I	MPUT								
	0900									BOB ROS	S MANE	L 7325	5 TECH.	MRP2							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PR0 #40P NR <---><--->

1234567890123456 ELSE PUT IN END

				LABOR STAI	NDARD	OPERATION RESOURCE STANDARI	) AND METHOD ANALYSIS	11/01/8	3 A-E0	46B-MM1	-DY-M45	PAGE 0001
	15:	139A	B.	52 M WHEEL	3-11	92 RCC	: MNPRA	4W1-7-114	13 900-97	39		
ER	TECH	s s	W	f PF A/R REV								
SUB		T K	#R	a fa support	000	< DESC	CRIPTION	<del></del> >	BASE	PFD	STD	A
	STEP	DL	K (	C DC ELEMENT	FACT	STORED	SUPPLEMENTAL		HOURS	TIME	HOURS	DLY PCT C
1102	 S	E J	EA :	ı J88302	1.00	PERCENT ENGR 99.9	MACH. B52M. WHL. OUTBOA	so	1.34		1.34	
000	1	J	9 01	00	.00		PART NO. / N.S.N.		.000	.000	.000	0
	0010					300-255 N.S.	L.					
	0020					300-255-1 1630	0011112990					
001	0	J	01	15	.07		REM BEARING BORE BUS	I,LARGE	.846	.009	.068	5
	0010	Ε		RML-SU-V3	. 25	S/U VERT HIL BORE FXTR HOIS	STPRORATE OVER 8 PARTS		1.0368	7	. 298	
	0020	Ε		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAN	P JIG BORE		. 1577	6	. 181	
	0030	Ε		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD			.1269	9	. 146	
	v40	Ε		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.0760	9	.087	
	0050	Ε		KMM-BA-LB	1.00	BORE HOLE 6 X 1 GROUP 1	•		.2162	6	. 248	
	0060	Ε		RJP <del>-PW-R</del> 1	1.00	REM RPL PAPRIME SIGN OFF DO	nc		.0100	1	.011	
006	0	J	01	15	.05		MACHINE MATTING SURF	*CE	.263	.002	.015	1
	0010	Ε		RLA-SU-S3	.25	SET UP SMALL NEDIUM LATHE	PRORATE OVER 4 PARTS		. 4996	2	.143	
	0020	Ε		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUC	*		.0100	6	.011	
	0030	Ε		KML-TA-JC	1.00	DIA 5.00-6.00 REN .033250	)		.0919	3	.105	
	0040	£		KML-TA-JD	1.00	DIA 6.0 REM .250 ADD INCH			. 0266	5	.030	
	0050	E		RJP <del>-PW-R</del> 1	1.00	REM RPL PAPRIMIK SIGN OFF DO	nc ·		.0100	1	.011	
007	0	J	01	15	.05		VALVE STEM HOLE REP I	RAD DR	. 459	.003	.026	2
	0010	Ε		RDR-SU-R1	. 25	S/U TO O/S BOSSES RAD DRILL	. PRORATE OVER 8 PARTS		.5637	8	.162	
	0020	E		RDR-80-A1	1.00	O/S BOSS W/STEP RMR RAD DRU	•		.3046	3	.350	
	7030	E		RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDE	:S		.0042	3	.004	
	0040	Ε		RJP <del>-PW-R</del> 1	1.00	REM RPL PAPRAMIK SIGN OFF DO	x		.0100	1	.011	
009	0	J	01	15	.05		REP TIE BOLT HOLE, RAI	DRILL	4.658	.035	. 268	20

_							
•	0010 E	RDR-SU-R1	. 25	S/U TO G. L BOSSES RAD DRILL PROPATE OVER 8 PARTS	.56378	.162	
	0020 €	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	. 350	
	)30 E	RDR-80-A2	26.00	O/S ADNL BOSS STP RMR RAD DROCCURRANCE = NUMBER OF HOLES	.14687	4.391	
	0040 E	KAL-SM-31	27.00	SPOT-FACE OR COUNTERBORE OCC.FOR NO.OF HOLES	.00423	.131	
	0050 E	RBW-DB-A1	27.00	DEBUR HOLE/CUTOUT BOTH SIDES OCC. FOR NO. OF HOLES	.01001	.310	
	0060 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
015	50 JA 01	15	.05	BEARING BORE SEAT REP, MED	.812	.006 .047	3
	0010 E	RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 8 PARTS	.80167	.230	
	0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WHAP 2 CLAMP JIG BORE	. 15776	.181	
	0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
	0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
	0050 E	RML-BA-LB	1.00	BORE HOLE 6 X 1 GROUP 1	.24122	.277	
	0060 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
016	O JA 01	15	.07	BEARING BORE REP - JI6 BORE	.812	.009 .065	5
_	0010 E	RML-SU-V2	. 25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167	.230	
	υ020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
	0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
	0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
	0050 E	RML-BA-LB	1.00	BORE HOLE 6 X 1 GROUP 1	.24122	.277	
	0060 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
018	O JA 01	15	.07	BRNG. BORE LK. RG. GROOVE	.597	.006 .048	4
	0010 E	RML-SU-V2	.25	S/U VERT MILL BORE LRS FIXTRPRORATE OVER 4 PARTS	.80167	.230	
	0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
	0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROO	. 12699	.146	
	0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
	0050 E	KML-TA-JD	1.00	DIA 6.0 REM .250 ADD INCH	.02665	.030	
	0060 E	RJP <del>-PW-R</del> 1	1.00	REH RPL PAPRWRK SIGN OFF DOC	.01001	.011	
<b>V</b> .	JA 01	15	.05	CRACKED WHEEL N. HOLE	.459	.003 .026	2
	0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
	0020 E	RDR-80-A1	1.00	D/S BOSS W/STEP RMR RAD DRL	.30463	.350	

0030 E RBM-DB-	A1 1.00 DEBUR HOLL CUTOUT BOTH SI	DES	.00423	.004	
0040 E RJP-PN-	R1 1.00 REH RPL PAPRWRK SIGN OFF	DOC	.01001	.011	
JA 01 15	.05	CRACKED TIME C. HOLE	.459 .003	.026	2
0010 E RDR-SU-	R1 .25 S/U TO O/S BOSSES RAD DRI	LL PRORATE OVER 4 PARTS	. 56378	.162	
0020 E RDR-BO-	A1 1.00 D/S BOSS W/STEP RMR RAD D	RL	.30463	.350	
0030 E RBM-DB-	1 1.00 DEBUR HOLE/CUTOUT BOTH SI	DES	.00423	.004	
0040 E RJP- <del>PW-</del> I	R1 1.00 REM RPL PAPRWRK SIGN OFF	DOC	.01001	.011	
0250 JA 01 15	.05	INST TIE BOLT BUSHING	.613 .005	.035	3
0010 E RBW-BU-	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	. 18669	.053	
0020 E RBW-BU-	4 27.00 INSTALL ONE STRAIGHT BUSH	ING OCC. FOR NO. OF BUSHINGS	.02062	.640	
0030 E RJP- <del>PW-</del> F	1 1.00 REM RPL PAPRWRK SIGN OFF I	ooc	.01001	.011	
0260 JA 01 15	.61	INST CUP INTO BUSHING	.077 .007	.054	4
0010 E RBW-BU-S	25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053	
0020 E RBW-BU-A	4 1.00 INSTALL ONE STRAIGHT BUSHI	ING	.02062	.023	
0030 E RJP <del>-PW-</del> F	1 1.00 REM RPL PAPRWRK SIGN DFF I	ooc	.01001	.011	
JA 01 15	.61	MACH BEARING BORE BUSHING	.236 .022	.166	12
0010 E RLA-SU-S	3 .25 SET UP SHALL MEDIUM LATHE	PRORATE OVER 8 PARTS	. 49962	.143	
0020 E RLA-HP-0	1 1.00 1ST PART IN-OUT SCROLL CHU	<b>n</b> ox	.01006	.011	
0030 E KML-TA-J	C 1.00 DIA 5.00-6.00 REM .03325	0	.09193	.105	
0040 E RJP-PW-R	1 1.00 REM RPL PAPRWRK SIGN OFF D	oc	.01001	.011	
0270 JA 01 15	.61	INST BEARING BORE BUSH & CUP	.077 .007	.054	4
0010 E RBM-BU-S	1 .25 SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669	.053	
0020 E RBN-BU-A	4 1.00 INSTALL ONE STRAIGHT BUSHI	NG	.02062	.023	
0030 E RJP-PW-R	1 1.00 REH RPL PAPRWRK SIGN OFF D	oc	.01001	.011	
0290 JA 01 15	.05	INST CUP INTO BUSHING	.077 .001	.004	0
0010 E RBM-BU-S	. 25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053	
0020 E RBM-BU-A	4 1.00 INSTAL ONE STRAIGHT BUSHI	NG	.02062	.023	
1030 E RJP-PW-R	L 1.00 REM RPL PAPRWRK SIGN OFF D	oc	.01001	.011	
285 JA 01 15	.05	MACH.OD OF BUSH. CUP ASSY.	.547 .004	.031	2
0010 E RLA-SU-S	3 .25 SET UP SHALL HEDIUM LATHE	PRORATE OVER 4 PARTS	. 49962	.143	

0020 E	RLA-HP-C1	1.00 1ST PARTOUT SCROLL CHU	ox 🦳	.01006	.011
0030 E	KML-TD-JC	1.00 DIA 5.00-6.00 REM .033250	0	. 40208	.462
10 E	RJP- <del>PW-R</del> 1	1.00 REM RPL PAPRNIRK SIGN OFF DO	oc	.01001	.011
0290 JA 01	15	.05	INST BEARING BORE BUSH & CUP	.077 .001	.004 0
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	. 18669	.053
0020 E	RBM-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHIN	NG	.02062	.023
0030 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DO	OC	.01001	.011
0330 JA 01	15	1.00	INSTALL HELICOILS	.348 .052	.401 30
0010 E	RBW-SU-H1	1.00 SET UP TO INSTALL HELICOILS	S	.31093	.357
0020 E	RBW-TR-H1	1.00 INSTALL HELICOIL INSERT		.02763	.031
0030 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DO	DC	.01001	.011
9000 JA 00	15	.00	LABOR STANDARD HISTORY	.000 .000	.000 0
0001		06MAY85 MATCHED WITH 958 FO	OR OUTED HALF		
0002		AND AS PER OCC.FACT.STUDY.	NEW OP NO.		
0003		AU685 ADDED PF&D TIME TO E	STDS. (TM WAS 2.26)		
.004		210CT85 2 YEAR REVIEW			
0005		8AUG86 IMPLEMENTED TIME ST	UDIES COMPLETED ON		
0006		SUBOP 0110/ WORK PREVIOUSLY	y worked on operation		
0007		M0010 (OLD STD 2.38)	•		
8000		LDEC86 CHANGED SUB-OPP0090	DUEPTO A METHODS		
0009		IMPROVEMENT (OLD STD 1.66)			
0010		20MAY87-DELETED SUBCPS 0080	0/0110 OLD STD 1.59		
0011		& NEW SUBOPPS ADDED OLD TIE	ME WAS 1.10		
0900		KERRY COOP MANEL TE	CHN 73357		

## TO TO TROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

תמאתואלם מחמאו	COCCATION	בספכתו ופרכ	CTANDADD	AM	METLIAN	ANAI VCTC	11/01/09	A-ENALD-MM1-DV-MAS	DACE	0001

						LAB	DR STAN	(DARD	OPERATION RESOURCE STAN	NDARD	AND METHOD ANALYSIS	11/01/88	A-E04	6B-MM1	-DY <del>-H4</del> 5	PAGE	0001
	15	139	7A	i	352	H W	HEEL.	3-119	72	RCC	HNPRA	4W1-7-114	3 <b>900-97</b> 3	9			
PER	TECH	S	S	₩	F	PF A	/r rev										
SUB	ŀ	T	K	#R	A I	FA SI	UPPORT	OCC	<- <del></del>	DESCR	RIPTION	<del></del> >	BASE	PFD	STD		Α
	STEP	D	L	K	C j	DC EI	e <b>ye</b> nt	FACT	STORED		SUPPLEMENTAL		HOURS	TIME	HOURS	DLY 1	PCT C
RA105	S	Ε	JA	EA	1	J	88300	. 65	PERCENT ENGR 92.6		MACH.B-52M.WHEEL INBO	) <b>.</b>	2.19		1.42		<del></del> <del>-</del> -
000	1		JA	01	(	00		.00			PART NUMBER / N.S.N.		.000	.000	.000		0
	0010								300-254	N.S.L							
	0020								300-254-1	16300	11119667						
001	0		JA	01		15		.05			REMV DR.KEY INDEX BUS	HING	.669	.005	.039		2
	0010	Ε				GJP-	-TL-A1	1.00	JOB PREPARATION GENERAL	-			.11960	ı	.137		
	0020	N						9.00			REMOVE KEY BUSH.OCC.	9EA.	.06000		.621		
	0030	Ε				RJP-	-PW-R1	1.00	REM RPL PAPRWRK SIGN OF	F DOC	,		.01001		.011		
	),		JA	01		15		. 46			REM BEARING BORE BUSH	,LARGE	.863	.060	. 457		21
	0010	Ε				RML-	-SU-V3	.25	S/U VERT MIL BORE FXTR	HOIST	Frorate over 8 parts		1.03687		.298		
	9020	Ε				RML	-HP-CC	1.00	HOIST HANDLE NO WRAP 2	CLAMP	JIG BORE		. 15776		.181		
	0030	Ε				RML	-AL-AB	1.00	ALIGN VERTICAL AXIS ROT	)			. 12699		.146		
	0040	Ε				RML	-AL-AC	1.00	ALIGN HOLE TO SPINOLE R	80D	•		.07609		.087		
	0050	Ε				K <del>P91</del>	-BA-LB	1.00	BORE HOLE 6 X 1 GROUP 1	l	USE PROPER ELEMENT/TA	BLE	.23311		.268		
	0060	Ε				RJP-	-PW-R1	1.00	REH RPL PAPRWRK SIGN OF	F DOC			.01001		.011		
005	0		JA	01		15		.05			FUSE PLUG HOLE REPAIR		.753	.006	.043		2
	0010	Ε				RDR-	-5U-R1	.25	s/u to o/s bosses rad d	RILL	PRORATE OVER 8 PARTS		. 56378		.162		
	0020	Ε				RDR-	-BO-A1	1.00	o/s boss w/step rmr rad	DRL			. 30463		.350		
	0030	Ε				RDR-	-BO-A2	2.00	O/S ADNL BOSS STP RMR R	RAD DR	OCCURRANCE = NUMBER O	F HOLES	. 14687		.337		
	0040	Ε				RBW	-D <del>B-</del> A1	1.00	DEBUR HOLE/CUTOUT BOTH	SIDES	;		.00423		.004		
	2050	Ε				RJP	-PW-R1	1.00	REH RPL PAPRHRK SIGN OF	F DOC	;		.01001		.011		
006	0		JA	01		15		.05			MACH. MATTING SURFACE		. 459	.003	.026		1
	0010	Ε				RDR-	-5U-R1	.25	S/U TO O/S BOSSES RAD D	RILL	PRORATE OVER 8 PARTS		.56378		.162		

0020 E R	RDR-80-A1 1.00	D/S BOSS TIPP RHR RAD DRL		30463	.350	
0030 E R	RBW-DB-A1 1.00	DEBUR HOLE/CUTOUT BOTH SIDE	3	.00423	.004	
40 E R	RJP <del>-PW-R</del> 1 1.00	REM RPL PAPRWRK SIGN OFF DO		.01001	.011	
0070 JA 01 15	.05		SPOT FACE TIE BOLT HOLES	.722	.005 .042	2
0010 E R	RDR-5U-R1 .25	S/U TO O/S POSSES RAD DRILL	PRORATE OVER 8 PARTS	.56378	.162	
0020 E R	RML-HP-H1 1.00	PART ON/OFF MACH HAND NO RA	٠,	.03068	.035	
0030 E K	(AL-SM-31 27.00	SPOT-FACE OR COUNTERBORE	OCC. FOR 27 FACES	.02004	.622	
0040 E R	RJP-PW-R1 1.00	REM RPL PAPRWRK SIGN OFF DO	2,	.01001	.011	
0080 JA 01 15	.05		REP TIE BOLT HOLE, RAD DRILL	4.278	.032 .246	11
0010 E R	OR-SU-R1 .25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 8 PARTS	.56378	.162	
0020 E R	RDR-BO-A1 1.00	D/S BOSS W/STEP RMR RAD DRL		.30463	.350	
0030 E R	RDR-BO-A2 26.00	O/S ADNIL BOSS STP RMR RAD DI	ROCC. FOR 26 HOLES	.14687	4.391	
0040 E R	RBW-DB-A1 1.00	DEBUR HOLE/CUTOUT BOTH SIDES	5	.00423	.004	
0050 E R	RJP <del>-PW-R</del> 1 1.00	REM RPL PAPRWRK SIGN OFF DOO		.01001	.011	
0087 JA 01 15	.05		BEARING BORE SEAT REP, LARGE	.846	.006 .049	2
NIO E R	8ML-SU-V3 .25	S/U VERT HIL BORE FXTR HOIS	IPRORATE OVER 8 PARTS	1.03687	.298	
0020 E R	ML-HP-CC 1.00	HOIST HANDLE NO WRAP 2 CLAM	JIG RORE	.15776	.181	
0030 E R	RML-AL-AB 1.00	ALIGN VERTICAL AXIS ROD		. 12699	.146	
0040 E R	ML-AL-AC 1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087	
0050 E K	GML-TD-JC 1.00	DIA 5.00-6.00 REM .033250		.21626	. 248	
0060 E R	RJP-PW-R1 1.00	REM RPL PAPRWAK SIGN OFF DOL	:	.01001	.011	
0090 JA 01 15	.46		BEARING BORE REP, PENSOTTI	.508	.035 .269	12
0010 N	1.00		SET UP PENSOTTI	.16700	.192	
0020 E	1.00	4 .26	MACHINE BEARING BORE	. 29333	.337	
0030 E R	RJP-PW-R1 1.00	REM RPL PAPRWAX SIGN OFF DO	C/	.01001	.011	
0040 E R	PL <del>-MI-</del> P1 1.00	GET PALLET JACK & MOVE PARTS	6/	.03815	.043	
0100 JA 01 15	.05		DRIVE KEY HOLE REP RAD DRL	2.930	.022 .169	8
7010 E R	10R-5U-R1 .25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 8 PARTS	.56378	.162	
0020 E R	DR-BO-A1 9.00	O/S BOSS W/STEP RMR RAD DRL	OCC. = 9 HOLES	.30463	3.152	
0030 E R	28M-DB-A1 9.00	DEBUR HOLE/CUTOUT BOTH SIDES	OCC. = 9 HOLES	.00423	.043	

l					••	-				
	0040	Ε	RJP-PW-R1	1.0	) REH RPL F WIRK SIGN OFF DOC		.01001	ļ	.011	
(	0110	JA 01	15	.07	MACH. DVE.KEY INDEX HO	ILES	2.930	.031	.236	11
(	.0	Ε	RDR-SU-R1	. 25	S S/U TO D/S BOSSES RAD DRILL PRORATE OVER 8 PARTS		.56378	3	.162	
	0020	Ε	RDR-BO-A1	9.00	0/S BOSS W/STEP RMR RAD DRL OCC. = 9 HOLES		.30463	3	3.152	
	0030	ε	RBW-DB-A1	9.00	DEBUR HOLE/CUTOUT BOTH SIDES OCC. = 9 HOLES		.00423	;	.043	
	0040	Ε	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
C	0120	JA 01	15	.46	MACHINE ID KEY SEAT AR	EA TO	. 487	.034	. 258	12
	0001				REMOVE CORROSSION					
	0010	N		1.00	SET UP PENSOTTI		.08000		.092	
	0020	E		2.50	3 .53 B52 MLG WHL HLF KEY SE	AT	.14383		.413	
	0021				REPAIR 1 CUT PENSOTTI/OCC AT 2.50/1 TO 4 CUTS/					
	0030 (	Ε	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC/		.01001		.011	
	0040	Ε	RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/		.03815		.043	
0	140	JA 01	15	.05	BRNG, BORE LOCK RING GRO	DOVE	.787	.006	.045	2
	0010 8	Ē	RML-SU-V2	. 25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS		.80167		. 230	
	W20 8	Ē	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		. 181	
	0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
	0040 E	•	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
	0050 8	•	KML-TA-JD	1.00	DIA 6.0 RES .250 ADD INCH		.21626		.248	
	0060 E	Ē	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0	150	JA 01	15	.05	CRACKED WHEEL W. HOLE		.459	.003	.026	1
	0010 E		RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS		.56378		.162	
	0020 E	Ē	RDR-BO-A1	1.00	D/S BOSS M/STEP RMR RAD DRL		.30463		.350	
	0030 E	:	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
	0040 E	i .	RJP- <del>PW-</del> R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0:	155	JA 01	15	.05	CRACKED TIME C. HOLE		. 459	.003	.026	1
	0010 E		RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PROPATE OVER 4 PARTS		.56378		. 162	
	120 E		RDR-80-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		. 30463		.350	
	0030 E	•	38M-08-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
	0040 E		RJP-PW-R1	1.00	REH RPL PAPRWRK SIGN OFF DOC		.01001		.011	

020	0	JA	01	15	.05		INST TIE BOLT HOLE BUSHINGS	.677	.005	.039	2
	0010 E			RRW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
	20 E			REW-BU-A2	27.00	INSTALL SET STRAIGHT BUSHIN	6 OCC. FOR 27 BUSHINGS	.02299		.713	
	0030 E			RJP <del>-FW-R</del> 1	1.00	REM RPL PAPRWRK SIGN OFF DO	С	.01001		.011	
020	4	JΑ	01	15	.05		INST CUP INTO BUSHING	.077	.001	.004	0
	0010 E			RBW-BU-S1	. 25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.গহ্য	
	0020 E			rew-eu-a4	1.00	INSTALL ONE STRAIGHT BUSHIN	6	.02062		.023	
	0030 E			RJP <del>-PW-R</del> 1	1.00	REM RPL PAPRWRK SIGN OFF DO	С	.01001		.011	
020	8	JA	01	15	.05		MACH BEARING BORE BUSHING	.236	.002	.014	1
	0010 E	:		rla-su-s3	. 25	set up small medium lathe	PRORATE OVER 8 PARTS	.49962		.143	
	0020 E			RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUC	K	.01006		.011	
	0030 E			KML-TA-JC	1.00	DIA 5.00-6.00 REM .033250		.09193		.105	
	0040 E			RJP- <del>PW-</del> R1	1.00	REM RPL PAPRWIRK SIGN OFF DO	C	.01001		.011	
021	0	JA	01	15	.05		INST BEARING BORE BUSH & CUP	.077	.001	.004	0
	0010 E			RBW-BU-S1	. 25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
	N20 E	:		rew-Ru-A4	1.00	INSTALL ONE STRAIGHT BUSHIN	6	.02062		.023	
	0030 E	;		RJP-PW-R1	1.00	ren rpl paprwrk sign off do	<b>C</b>	.01001		.011	
021	2	JA	01	15	.05		INST CUP INTO BUSHING	.077	.001	.004	0
	0010 E			RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
	0020 E	•		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHIN	6	.02062		.023	
	0030 E			RJP-PW-R1	1.00	REH RPL PAPRWRK SIGN OFF DO	C	.01001		.011	
021	6	JA	01	15	.05		TURN BUSHING GROUP 4/STEEL	.547	.004	.031	1
	0010 E			rla-su-s3	.25	SET UP SHALL MEDIUM LATHE	PRORATE OVER 4 PARTS	. 49962		.143	
	0020 E			RLA-HP-C1	1.00	IST PART IN-OUT SCROLL CHUC	<b>(</b>	.01006		.011	
	0030 E	•		KML-TD-JC	1.00	DIA 5.00-6.00 REM .033250		.40208		.462	
	0040 E			RJP <del>-PW-R</del> 1	1.00	REH RPL PAPRWRK SIGN OFF DOO	E	.01001		.011	
0220	)	JA	01	15	.05		INST BEARING BORE BUSH & CUP	.077	.001	.004	0
	110 E	•		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	. 18669		.053	
	0020 E			KÎSW-DU-A4	1.00	INSTALL ONE STRAIGHT BUSHIN	8	.02062		.023	
	0030 E	•		RJP <del>-PW-R</del> 1	1.00	REN RPL PAPRWRK SIGN OFF DOO		.01001		.011	

)225 JA	01	15	.05		TURN BUSHING GROUP 4/STEEL	1.206	.009	.069	3
0010 E		RLA-SU-S3	.25	SET UP SHALL MEDIUM LATHE	PRORATE OVER 4 PARTS	. 49962		.143	
0 E		RLA-HP-C1	9.00	1ST PART IN-OUT SCROLL CHUC	K OCC. FOR 9 BUSHINGS	.01006		.104	
0030 E		KML-TD-CC	9.00	DIA .501-1.00 REM .033250	OCC. FOR 9 BUSHINGS	.10898		1.127	
0040 E		RJP <del>-PW-R</del> 1	1.00	REM RIPL PAPRWIRK SIGN OFF DOM	C	.01001		.011	
1230 JA	01	15	.05		INSTALL KEY B.HOLE BUSH.	.242	.002	.014	1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	. 18669		.0ವ	
0020 E		rbw-bu-a4	9.00	INSTALL ONE STRAIGHT BUSHING	6 OCC FOR 9 BUSHINGS	.02062		.213	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOK	C	.01001		.011	
1235 JA	01	15	.05		TURN BUSHING GROUP 4/STEEL	1.206	.009	.069	3
0010 E		RLA-SU-S3	. 25	SET UP SMALL HEDIUM LATHE	PRORATE OVER 4 PARTS	. 49962		.143	
0020 E		RLA-HP-C1	9.00	1ST PART IN-OUT SCROLL CHUCK	K OCC. FOR 9 BUSHINGS	.01006		.104	
0030 E		KML-TD-CC	9.00	DIA .501-1.00 REM .033250	OCC. FOR 9 BUSHINGS	10898		1.127	
0040 E		RJP <del>-PW-R</del> 1	1.00	REM RPL PAPRWARK SIGN OFF DOO	2	.01001		.011	
)240 JA	01	15	.05		INST STRAIGHT BUSH NO POLISH	.242	.002	.014	1
.√10 E		RBW-BU-S1	. 25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBH-BU-A4	9.00	INSTALL ONE STRAIGHT BUSHING	6 OCC. FOR 9 BUSHINGS	.02062		.213	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOX		.01001		.011	
000 JA	00	15	.00		•	.000	.000	.000	0
0001				07MAY85 DIV WHL INTO 2 OP.&	MATCHED WITH				
0002				958 AND C/N OCC FAC STUDY )	TH WAS 5.80)				
0003				13MAY85 DELETED SUB OPS 10,2	20,30,40,DIPL				
0004				AUGUS ADDED PF&D TIME TO E S	STDS (TH WAS 1.28)				
0005				210CT85 2 YEAR REVIEW					
0006				BAUSS6 IMPLEMENTED TIME STU	DIES COMPLETED ON				
0007				SUBOPS 0100 & 0140/ WORK PRI	EVIOUSLY WORKED ON				
8000				OPERATION MOOZO/ (OLD STD 1.	.21)				
1109				1DED86 CHANGED SUB-OP 0070 I	DUE TO A METHODS				
0010				IMPROVEMENT (OLD STD 1.41)					
0011				NEW SUBOPPS ADDED 0010/00116	REMOVE BUSHINGS				

OCC. FAC. CASED FOR 27 BUSH.

0900

KERRY COOP MANEL TECHN 73357

INTERROGATE LABOR STANDARDS, INPUT

OC PRD NROP NR

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34567890123456 ELSE PUT IN END

C102 S E UP EA B J 88302 1.00 PERCENT ENGR 96.8 8-52M.WHEEL HALF OUTBOARD 1.98 1.98

0001	UP 01	00	.∞	PART NO. / N.S.N.	.000	.000	.000	0
0010			300 <b>-255</b>	N.S.L.				
0020			300-255-1	1630011112990				
0225	UP 01	24	1.00	DEGREASE	.150	.036	.187	9
0010	Ε	RPL-DE-L1	1.00 DEGREASE LARGE PART OF	r Baskt	.14095		.174	
0020 8	•	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN C	OFF 00C	.01001		.012	
0230	UP 01	24	1.00	SHOTPEEN LARGE PART/MASK	.848	.204	1.052	ឆ
J010 I	E	ZMA-CL-04	1.00 MASK V/LRG CYL TYPE PA	art	.32667		.405	
0020	Ε	RPL-SP-L1	1.00 SHOT PEEN LARGE PART	,	. 46073		.571	
0030 1	ч	ZUM-CL-02	1.00 UNMASK MEDIUM SIZE CYL	_ PART	.05067		.062	
0040	Ē	RJP-PW-R1	1.00 REM RPL PAPRMRK SIGN (	DFF DOC	.01001		.012	
0240	UP 01	24	1.00	ANODIZE LARGE PART	.604	.145	.749	.8 38
0010 (	Ē	RWB-CV-D1	1.00 VAPOR CL (DESR)HOOK/BA	asket	.08709		.107	
0020 (	Ē	ZPL-AN-L1	1.00 ANODIZE LARGE SIZE PAR	रा	.50714		.628	
0030 (	Ε	RJP-PW-R1	1.00 REM RPL PAPRHIRK SIGN (	DFF DOC	.01001		.012	
9000	UP 0!	24	.01	LAROR STD HISTORY	.000	.000	.000	0

0010 20NOV85 WRDTE STD TO WATCH 958 (NEW STD)

0900 KERRY COOP MANEAA TECHN 73357

## 34567890123456 ELSE PUT IN END



`ARC105

				LABOR STA	www.	OPERATION RESOURCE STA	ANDARD AND METHOD ANALYSIS	11/01/8	3 A-E0	46B-MM	I-DY-M45	PAGE	0001
	151	39A	E	352 ML6 ₩HL 3-	-1192		RCC MNPRC 4	W1-7-114	13 900-97	39 8	31157		
-ER	TECH S	S S	W	f PF A/R REV									
SUB		TK	粎	a fa support	OCC	<- <del></del>	- DESCRIPTION	<del></del> >	BASE	PFD	STD		A
	STEP !	D L	K	C DC ELEMENT	FACT	STORED	Supplemental		HOURS	TIME	HOURS	DLY	PCT C
C10 <b>5</b>	s (	E UP	EΑ	B J 88301	1.00	PERCENT ENGR 76.8	8-52 MAIN WHL.HALF IND	iD.	1.98		1.98		
000	1	UP	01	00	.00		PART NO. / N.S.N.		.000	.000	.000		0
	0010					300-254	N.S.L.						
	0020					300-254-1	1630011119667						
017	0	UP	01	24	1.00		DEGREASE		.150	.036	.187		9
	110 i	Ē		RPL-DE-L1	1.00	DEGREASE LARGE PART OF	R BASKT		.1409	5	.174		
	0020	E		RJP <del>-P₩-R</del> 1	1.00	REN RPL PAPRWRK SIGN O	FF 00C		.0100	1	.012		
018	0	UP	01	24	1.00		SHOTPEEN LARGE PART/MA	SK	.848	.204	1.052		53
	0010 6	E		ZMA-CL-04	1.00	MASK V/LRG CYL TYPE PA	PRT		.3266	7	.405		
	0020 8	E		RPL-SP-L1	1.00	SHOT PEEN LARGE PART			. 4607.	3	.571		
	0030	¥		ZUM-CL-02	1.00	unmask hedium size cyl	. PART		.05067	7	.062		
	0040 8	Ē		RJP <del>-PW-R</del> 1	1.00	REM RPL PAPRWRK SIGN C	OFF DOC		.0100	l	.012		
019	0	UP	01	24	1.00		ANODIZE LARGE PART		.604	. 145	.749	.8	38
	0010	Ξ		RWB-CV-D1	1.00	VAPOR CL (DEGR)HOOK/BA	SKET		.0870	9	.107		
	0020 8	Ξ		ZPL-AN-L1	1.00	ANUDIZE LARSE SIZE PAR	ग		.50714	,	.628		
	0030 8	Ē		RJP <del>-PW-R</del> 1	1.00	REM RPL PAPRIARK STGN (	OFF DOC		.0100	l	.012		
900	0	UP	01	24	.01		LABOR STD HISTORY		.000	.000	.000		0
	0010					20NOV85 WROTE STD TO M	NATCH 958 (NEW STD)						
	00					KERRY COOP HANE	AA TECHN 73357						

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E0468-MM1-DY-M45 PAGE 0001 J139A B52 M WHEEL 3-1192 rcc inipgp 4W1-7-1143 900-9739 81043 R TECH S S W F PF A/R REV T K #R A FA SUPPORT OCC (------ DESCRIPTION ----- BASE PFD STD SUB STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

	0.0	•		^	•	où cealest.		o i onico	53. , <u>25.</u> 5	1.00.10		reario	527 107 0
10	S	Ε	ΥH	EA	5	J 88300	1.00	PERCENT ENGR 99.9	ASSY. WHEEL 8-52 M.	2.00		2.00	
000	)1		ΥH	01		00	.00		PART NO. / N.S.N.	.000	.000	.000	0
	0010	)						3-1192	1630009009739				
	0020	)						3-1192-1	1630012286043				
001	5		ΥH	10		21	1.00		ASSEMBLE WHEEL	1.654	.348	2.002	100
	0005	Ε				RWB-OH-W2	2.00	REMV WHIL HLF F/PAINT C	ONVYORZNHEEL HALVES	.0083	3	.020	
	0010	) E				RWB-JP-W2	1.00	PREP TO ASSY OR DISSY	WEEL	.0044	2	.005	
	0011	Ε				RMH-FW-S3	1.00		FINAL CK-INSP PARTS	.1957	7	.236	
	120	) Ε				RWB-BC-03	2.00	INSTALL BEARING CUPS		.1683	3	.407	
	0030	) E				RWB-BB-01	2.00	BALANCE WHEEL HALF	`	.0773	4	.187	
	0040	3 (				RWB-UP-P8	1.00	UNPK PARTS-BK KEY-TIE	BOLT	.08482	2	.102	
	0050	) E				RWB-AW-T1	27.00	INSTL UNOBSTRUCTED TIE	BOLT	.0097	5	.318	
	0060	) E				RWB-AW-K2	9.00	INSTL BRAKE KEY/MULTI-	SCREW	.0164	2	.178	
	0070	) E				RWB-AW-TF	3.00	REPLACE THERMAL FUSES		.0616	2	.223	
	0080	) E				RWB-AW-B1	2.00	INSTL BEARNG/SNAP RNG	SECURO	.02459	7	.059	
	0100	) E				RWB-AN-H3	1.00	INSTL SINGLE PC HEAT S	HIELD	.00366		.004	
	0110	) E				RWB-NB-02	2.00	PROC TIME NCK / BUR LS	PART	.0473	3	.114	
	0120	) E				RWB-FT-01	1.60	FINAL & TUCH UP V/L LR	G WHEL	.1083	3	.131	
	0130	E				RJP <del>-PW-R</del> 1	1.00	REH RPL PAPRWRK SIGN D	FF DOC	.01001	ļ	.012	
900	ю		ΥH	U1		21	.00		LABOR STANDARD HISTORY	.000	.000	.000	0

OBJUNE4 ADD SUB OP 0001 BUNLDAD LINE(OLD STD) 1.85

26MAR85 2 YEAR REV NO CHNG (OLD TH 1.93)

3HAR86 CHANGED SKILL CODE FROM YG TO YH 0021

0023

0900

NO TIME SAGE

20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP

0010 WORK DONE BY DS PERSONNEL (OLD STD 1.93)

KERRY COOP MANEL TECHN 73357

O INTERROGATE LABOR STANDARDS, IMPUT

RCC PRD NROP NR

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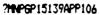
.234567890123456 ELSE PUT IN END

LAROR STA	INDARD OPERATION RESOURCE ST	TANDARD AND METHOD ANALYSIS 11/01/8	B A-E046B	-MM1-DY-M45	PAGE 0001
.5139A B52 M WHEEL	3-1192	RCC MNPGP 4W1-7-11	45 900-9739	81043	
ER TECH S S W F PF A/R REV	ı				
SUB TK #RAFASUPPORT	OCC <	- DESCRIPTION>	BASE PF	OTS O	A
STEP D L K C DC ELEMENT	FACT STORED	Supplemental	HOURS TI	ME HOURS	DLY PCT C
1106 S E YH EA 5 J 88300	1.00 PERCENT ENGR 84.5	MATCH UP WHEEL 852M.	.13	.13	
0001 YH 01 00	.00	PARTS NO. / N.S.N.	.000 .0	.000	0
0010	3-1192	1630009009739			
0020	3-1192-1	1630012286043			
0010 YH 01 21	1.00	WHEEL MATCH UP	.110 .0	023 .134	100
0010 E MGT-EE-24	1.00 SET EASY AND PLACE EX	ACT	.00097	.001	
0020 E RWB-UP-P7	1.00 UNPK PARTS-BK KEY-SNAI	P RING	.08237	.099	
0030 N	1.00	NATCH WHEEL HALFS 2 HALFS	.01700	.020	
J40 E RJP <del>-PW-R</del> 1	1.00 REM RPL FAPRWRK SIGN (	OFF DOC	.01001	.012	
9000 YH 01 21	.00	LABOR STANDARD HISTORY	.000 .(	.000	0
0010	06JUN84 ADD SUB OP 004	01 %UNLOAD LINE(OLD STD> 1.85			
0020	26MAR85 2 YEAR REV NO	CHNG (OLD TH 1.93)			
0021	3MAR86 CHANGED SKILL (	CODE FROM Y6 TO YH			
0022	NO TIME CHANGE				
0023	20CT86 2 YEAR REVIEW,	DELETED STEP 0140 SUBOP			
0024	0010 WORK DONE BY DS F	PERSONNEL (OLD STD 1.93)			

KERRY COOP HANEL TECHN 73357

TO THE POGATE LABOR STANDARDS, INPUT

RCC PRID NROP NR



		•	- • •			L	ABOR STA	NDARD	OPERAT I	ON RESOLURCE	STANDARD AND HET	HOD ANALYSIS	04/25/89	0-F04	AR-MI	-DV-M45	PAGE 0001
		13				? M	MHEEL	3-11		911 NEBOUNOE	RCC IMPGP	740		3 900-973		31043	1 NOE 0002
الله الله	TECH STEP	7	K	#R	A	FΑ	A/R REV SUPPORT ELEMENT	occ		SIORED	DESCRIPTION	SUPPLEMENTAL	>		PFD TIME	STD Hours	DLY PCT C
PP106	S	Ε	35	EΑ	5	-	J 89116	1.00	PERCENT	ENGR 99.9	∵∂ <b>uc</b> ii-l	P PAINT B-52M	NHL	.07		.07	***********
000	!		35	01		00		.00			PARTS N	Ø. / N.S.N.		.000	.000	.000	0
	0010								3-1192		163000900973	<b>59</b>					
	0020								3-1192-	1	163001228604	13					
0020	)		35	01		25		1.00			PAINT 1	OUCH UP SH & I	MED	.063	.016	.080	100
	0010	Ε				RI	/B-FT-02	1.00	FINAL &	TUCH UP HE	D/SML WHEL			.05395		.067	
	0020	Ε				R	IP-PH-RI	1.00	REH RPL	PAPANAK SI	EN OFF DOC			.01001		.012	
9000	)		35	01		00		.00			LABOR S	TANDARD HISTO	RY	.000	.000	.000	0
	0010										9 INITIAL INPUT H	IRPII					·
	0900									BOB ROSS	MANEL-1 77126						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR (---->(---->)(----> 1234557890123456 ELSE PUT IN END LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E0468-MM1-DY-M45 PAGE 0001

15139A B52 N WHEEL 3-11°2 RCC MNPSP 4W1-7-1143 900-9739 81043	1043
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	12	127	'A	R	52 R	WHEEL,	3-11	φ <u>γ</u>	KUU	, mercer 4	<b>明1</b> -/-114.	3 400-47	24 9	31043		
PER	TECH	s	S	W	FPF	A/R REV										
SUB		T	K	iR i	A FA	SUPPORT	000	<b>&lt;</b>	- DESC	RIPTION	<del></del> >	BASE	PFD	STD	i	A
	STEP	D	L	K	CDC	ELEMENT	FACT	STORED		SUPPLEMENTAL		HOURS	TIME	HOURS	DLY PCT (	;
P102	S	Ε	35 (	Α :	 5	J 88302	1.00	PERCENT ENGR 99.9		PAINT WHEEL HALF 8-52M	•	π.		z.		•
0001	L		3 <b>S</b> (	)1	00	ı	.00			PART NO. / N.S.N.		.000	.000	.000	0	
	0010							300-255	N.S.	L.						
	0020							300-255-1	16300	11112990						
0360	)		3 <b>S</b> (	1	25		1.00			PAINT WHEEL		. 267	.067	. 334	4.0 100	
	0010	Ε			6	iPL-PA-01	4.00	INST NONTHREADED PLSTO	C PLUG	;		.0009	3	.004		
	0020	Ε			6	IG-SP-41	1.00	MASK & UNMASK MEDIUM F	PART			.0124	2	.015		
	0030	Ε			R	₩B-0H-₩1	1.00	HANG WHIL HLF ON PAINT	CONVY	R		.0233	6	.029		
	<i>3</i> 040	ε			R	W8-SC-02	1.00	PNT WHL HALF-ZINC CHRO	MATE			.1157	4	.144		
	0050	ε			R	WB-SC-P3	1.00	PNT WHIL HALF (2ND COAT	T)	POLY 2 COATS		.1021	4	.127		
	0060	Ε			R	JP <del>-PW-R</del> 1	1.00	REM RPL PAPRWRK SIGN (	OFF DO	С		.0100	1	.012		
9000	)		3 <b>S</b> (	)1	25	;	.00			LABOR STANDARD HISTORY		.000	.000	.000	0	
	0010							06JUNB4 REMOVE UNLOADI	ING PA	INT LINE (OLD STD) .57						
	0020							26MAR85 2 YEAR REV.NO	CHN6	(OLD TH .55)						
	0021							20CT86 2 YEAR REVIEW D	ELEDT	ED STEP 0060 WORK						

PERFORMED BY DS PERSONNEL (OLD STD .55)

KERRY COOP MANEL TECHN 73357

TO 1 PROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

0022

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 9001 5139A B52 M WHEEL 3-1192 RCC HNPGP 4W1-7-1143 900-9739 81043 TECHSS WEPFA/RREV STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C 105 S E 3S EA 5 J 88301 1.00 PERCENT ENGR 99.9 PAINT WHEEL HALF 8-52M z. .33 .000 .000 .000 PART NO. / N.S.N. 0 0001 3S 01 00 .00 300-254 N.S.L. 0010 300-254-1 1630010009667 0020 0290 35 01 25 PAINT I EEL .267 .067 .334 4.0 100 i.00 6PL -2A-01 4.00 INST NONTHREADED PLSTC PLUG 0010 E .00093 .004 616-SP-H1 1.00 MASK & UNMASK MEDIUM PART 0020 E .01242 .015 .02336 .029 0030 E RWB-OH-W1 1.00 HANG WHL HLF ON PAINT CONVYR .11574 .144 40 E RWB-SC-02 1.00 PNT WHL HALF-ZINC CHROMATE RWB-SC-P3 1.00 PNT WHL HALF (2ND COAT) POLY 2 COATS .10214 .127 0050 E .012 RJP-PNI-R1 1.00 REM RPL PAPRNIRK SIGN OFF DOC .01001 0060 E .000 .000 .000 LAROR STANDARD HISTORY 9000 35 01 25 .00 OBJUNBA REMOVE UNLOADING PAINT LINE (OLD STD) .57 0010 26MAR85 2 YEAR REV.NO CHING (OLD TH .55) 0020 20CT86 2 YEAR REVIEW DELEDTED STEP 0060 WORK 0021

PERFORMED BY DS PERSONNEL (OLD STD .55)

KERRY COOP MANEL TECHN 73357

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRO NROP NR

0022

				U	ABOR STAN	DARD	OPERATIO	IN RESOURCE	STANDAR	D AND METHOD ANALYSIS	11/01/88	A-E04	16B-1 <b>9</b> 11-	-DY-M45 i	PAGE	0001
	51	39A	85	i2 H	WHEEL	3-119	2		RC	C MNPGP	4W1-7-114	3 900-97	5 <b>9</b> 8:	1043		
					A/R REV				nco	CDVDTION	\	DACE	PFN	STD		A
										CRIPTION						
	STEP	DL	ΚŒ	D DC	ELEMENT	FACT				SUPPLEMENTAL			TIME	HOURS	DLY P	UI U
-106	Ε	N 39	EA S	 5	1 88200	1.00	PERCENT			PAINT ##EEL B-52M				. 48		
000	1	30	3 01	00	1	.00				PART NO. / N.S.N.		.000	.000	.000		
	0010						3-1192		16.	:0009009739						
	Y)20						3-1192-	1	16	50012286043						
002	0	39	5 01	25	i	1.00	)			PAINT TOUCH UP V/L L	-6E	.118	.030	.148		31
	0010	Ε		F	WB-FT-Ú1	1.00	FINAL &	TUCH UP V	/L LRG #	£L.		.108	8	.135		
								. Paprwirk s				.0100	01	.012		
099					5					FINAL ACCEPTANCE OF	W.C.D.	.132	.033	.166		34
	. 10					1.0				FINAL		. 380	00	.100		
	0020	) E		,	6JP-FP-85	1.0	0			FILL OUT FORM 424 &	ATTACH	.052	55	.065		
094	<del>7</del> 8	3	S 01	2	5	1.0	0			FINAL VISUAL INSPEC	TION	. 137	.034	.171		35
		N				1.0				FINAL VISUAL INSPEC	TION	.127	00	. 158		
	0020	) E			RJP <del>-PW-R</del> 1	1.0	O REDIRPI	L PAPRMIRK S	SISN OFF	DOC		.010	01	.612		
90	00		3S 01			.0				LABOR STANDARD HIST	'ORY	.000	.000	.000	•	0
	001	0					06J <b>un</b> 8	4 REMOVE LI	NLOADING	PAINT LINE (OLD STD)	.57					
	002						26MAR8	5 2 YEAR R	EV.NO CH	46 (DLD) 7H .55)						
	002						20CT86	2 YEAR RE	VIEW DELL	EDTED STEP 0060 WORK						
	002						PERFOR	RMED BY DS	PERSONNE	_ <0LD STO .55>						
	090							KERRY COO	P MANEL	TECHN 73357						

				LABOR STA	NDARD GPE	RATION RESOURCE ST	ANDARD	AND METHOD ANALYSIS	11/01/88	3 A-E0	46B-MM1	-DY- <b>H4</b> 5	PAGE 0001
	1513	59A	852	M WHEEL	3-1192		RCC	MNPGP	4W1-7-114	3 900-97	39 8	11043	
PER	TECH 9	SS	₩ F	PF A/R REV									
SUB	1	r K d	IR A	FA SUPPORT	000 <		- Desci	RIPTION	<del></del> >	BASE	PFD	STD	A
	STEP D	L	K C	DC ELEMENT	FACT	STORED		SUPPLEMENTAL		HOURS	TIME	HOURS	DLY PCT C
								·				<del></del>	
S102	S E	YH E	A 5	J 88302	1.00 PERC	ENT ENGR 95.9		PRE. INSP. MASSY. WHL. H	.F.852M.	.50		.50	
000	1	YH (	)1	00	.00			PART NO./ N.S.L.		.000	.000	.000	0
	0010				300-	255	N.S.L	••					
	0020				300-	255-1	16300	011112990					
035	0	YH C	)1	21	1.00			PREINSPECTION WHEEL H	IALF	7012	.003	.019	4
	0010 E			RWB-JP-W2	1.00 PREP	TO ASSY OR DISSY	WEEL			.0044	2	.005	
	0020 E			KAL-6C-46	1.00 INSP	ECT VISUAL				,00115	5	.001	
_	0030 E			RJP-P <del>W-R</del> 1	1.00 REM	RPL PAPRWRK SIGN (	OFF DOC	:		.0100	i	.012	
	<b>)</b>	YH C	1	21	1.00			RACE INSTALLATION WHL	./HALF	.178	.037	.216	43
	0010 E			RWB-BC-03	1.00 INST	ALL BEARING CUPS		`		.16838	3	.203	
	0020 E			RJP <del>-PW-R</del> 1	1.00 REM	RPL PAPRWRK SIGN (	OFF DOC	,		.01001	l	.012	
037	n	YH 0	1	71	1.00			BALANCE WHEEL HALF		.111	.023	.134	27
	0010 E			6PL-PD-01	4.00 REM	NONTHREADED PLAST!	IC PLUG	<b>;</b>		.00339	)	.016	
	0020 E			SMC-MT-D1	1.00 REMO	VE MASKING TAPE				.00191	ļ	.002	
	0030 E			RW8-0H-W2	1.00 REMV	WHL HLF F/PAINT (	CONVYOR	1		.00833	;	.010	
	0040 E			RWB-BB-01	1.00 BALA	NCE WHEEL HALF				.07734	}	.093	
	0050 E			RJP <del>-PW-R</del> 1	1.00 REM I	RPL PAPRWRK SIGN (	OFF DOC	;		.01001		.012	
0380	)	YH 0	1 :	21	1.00			WHEEL MATCH UP		.110	.023	.134	27
	6010 E			MGT-EE-24	1.00 GET 1	easy and place exp	VCT			.00097	•	.001	
	0020 E			RWB-UP-P7	1.00 UNPK	PARTS-BK KEY-SNAF	RING			. 08237	,	.099	
	7030 N				1.00			MATCH WHEEL HALFS 2	HALFS	.01700		.020	
	0040 E			RJP <del>-PW-R</del> 1	1.00 REH	RPI. PAPRWRK SIGN (	OFF DOC	}		.01001		.012	
9000	)	YH O	1 7	21	.00		1	LABOR STANDARD HISTOR	Y	.000	.000	.000	0

0010	OBJUNEA . Sub op 0001 Bunload Line(OLD STD) 1.85
0020	26MAR85 2 YEAR REV NO CHING (OLD TH 1.93)
21 '	3MAR86 CHANGED SKILL CODE FROM YG TO YH
0022	NO TIME CHANGE
0023	20CTB6 2 YEAR REVIEW, DELETED STEP 0140 SUBDP
0024	0010 WORK DONE BY DS PERSONNEL (OLD STD 1.93)
0900	KERRY COOP MANEL TECHN 73357

## J INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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.234567890123456 ELSE PUT IN END

				Labor Stai	NDARD	OPERATION RESOURCE STA	andard an	ID METHOD ANALYSIS	11/01/88	A-E0	46B- <del>111</del> 1	1-DY-M45	PA6E	0001
	.513	7A	852	H WHEEL	3-11	92	RCC MN	PSP	4W1-7-114	3 <del>9</del> 00–97	<b>39</b> (	31043		
ER	TECH S	S	₩ F	PF A/R REV										
SUB	T	K i	IR A	FA SUPPORT	900	<	- DESCRIP	TION	>	BASE	PFD	STD		A
				•		STORED				HOURS	TIME	HOURS	DLY	PCT C
3105						PERCENT ENGR 95.9			H.852M	.50		.50		
000	1	YH C	)1	00	.00		PA	RT NO. / N.S.N.		.000	.000	.000		0
	0010					300-254	N.S.L.							
	0020					300-254-1	1630010	009667						
0270	)	YH C	ì	21	1.00		PR	EINSPECTION WHEEL H	HALF	.015	.003	.019		4
	0010 E			RWB-JP-W2	1.00	PREP TO ASSY OR DISSY	WHEEL			.0044	2	.005		
	0020 E			KAL-6C-46	1.00	INSPECT VISUAL				.0011	5	.001		
	0030 E			RJP-PM-R1	1.00	REM RPL PAPRWRK SIGN O	OFF DOC			.0100	1	.012		
	1	ун с	ì	21	1.00		RA	CE INSTALLATION WHI	./HALF	.178	.037	.216		43
	0010 E			RWB-BC-03	1.00	INSTALL BEARING CUPS		1		. 1683	8	.203		
	0020 E			RJP <del>-P₩-R</del> 1	1.00	REM RPL PAPRWRK SIGN O	OFF DOC			.0100	l	.012		
0290	)	YH C	)1	21	1.00		BA	LANCE WHEEL HALF		.111	.023	.134		27
	0010 E			SPL-PD-01	4.00	REM NONTHREADED PLASTI	IC PLUG			.0033	7	.016		
	0020 E			GMC-MT-D1	1.00	REMOVE HASKING TAPE				.0019	l	.002		
	0030 E			RWB-OH-W2	1.00	REHV WHL HLF F/PAINT C	CONVYOR			.0083	3	.010		
	0040 E			RWB-BB-01	1.00	BALANCE WHEEL HALF				.0773	•	.093		
	0050 E			RJP-PN-R1	1.00	REM RPL PAPRWRK SIGN O	OFF DOC			.0100	l	.012		
0295	5	YH C	)1	21	1.00		WH	EEL MATCH UP		.110	.023	.134		27
	0010 E			MGT-EE-24	1.00	GET EASY AND PLACE EXA	CT			.00097	7	.001		
	0020 E			RWB-UP-P7	1.00	UNPK PARTS-BK KEY-SNAP	RING			.08237	7	.099		
	~30 N				1.00		HA	TCH WHEEL HALFS 2	HALFS	.01700	)	.020		

RJP-PN-R1 1.00 REM RPL PAPRNIRK SIGN OFF DOC

.00

YH 01 21

9000

.012

.000

.01001

LABOR STANDARD HISTORY

	+ 5x	~
0010	06JUN84 : SUB OP 0001 BUNLDAD LINE(DLD STD) 1.85	ŧ
0020	26MAR85 2 YEAR REV NO CHING (OLD TH 1.93)	
21	3MAR86 CHANGED SKILL CODE FROM YG TO YH	
0022	NO TIME CHANGE	
0023	20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP	
0024	0010 WORK DONE BY DS PERSONNEL (OLD STD 1.93)	
0900	KERRY COOP MANEL TECHN 73357	

J INTERROGATE LABOR STANDARDS, INPUT

RCC PRID NROP NR

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16-May-89

STL-STEEL
AL-MUNTH
ING-MORESIUM
IIIA-IIIANIUM
SS-S STL
SYM-SYNTHETIC
LD-LEAD

C-SB MAIN WHEEL

BILL OF MATERIALS

90101A

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	1 CODE		N. M. M. M. M. M. M. M. M. M. M. M. M. M.		AUTENCE I UNE	<b>E</b>	₽ ≅	TE IFAC	PER I OF IRATE IFACTORITYPE	CODEILEVEL	. <del>.</del> .	CONTROL	PER I OF INTELLEGENT PRINCIPLE CONTROL I CHE I 103   252	103	252	AFT0 22
						\$		. <u>.</u>   	R, D, C		<u> </u>	DATE	NUMBER	S	ACTION	ACTION
	. 2	4694000-117C	1630011826267	:98897	C-58 MAIN MEET ASSY	. =	 55		. <b></b>	 	- <b></b>					
	1.1	300-528-1	11630011084043	197153	. WEEL HALF ASSY (OUT-BOARD)	==	 55									
		N.P.L.	in.S.L.		:WEEL HALF SUBASSY (OUTBOARD)	=										
	2	N.P.L.	:N.S.L.		BUSHING & CUP ASSENBLY (PSEUDO)	æ =:										
	_	75112829	in.S.L.		BUSHING (BEARING CUP) (REPAIR)	==										
	_	6630310	13110002251916	80009	CUP. (BEARING)	==	 গ্র									
		BC285	5340008140267	1833		<u> </u>	5									
		E-085	5740011578690	BXT.	INSERT (ROZANI (NARSTZE)	14 AR!FA	 i &	·				•				
		10-1147-1	N S I	25170	HARFE MAYER CONTROLLAND	: : :	 i		- <b>-</b>	<b>!</b>		-				_
		10.115-1	IN S.L.	3 3	ANT APPOINT	: :	۔ ۔ ئ									
F		TSCWOTT 103G	C707C/70001CC:	37070	iNUI (MEJONI)	15 98 C1	 5 S									
ן מון		*/-/k	70COCCOOMCGI	3	i WELDIN (BRUNKE ) (0.302)	7	 5 i	<b>-</b> .	<b>-</b> .	. <u>.</u> :	. <b>.</b> .	-		<u> </u>		
킮		1897-X	1630008263028	312	:KEIGHT (BALANCE) (102)	12 PR ES	 5			<u> </u>						
		AMEO7C10X2-20	N.S.L.		ISCREW (MEIGHT)	æ ≅						••				
	12	HE24693E2B0	15305009586375	19690		11 PR ES	- 5	-	_		_ =	_				
띪	12	1630310	13110002251916	820091	=	.: Æ	 S			 						
	2	38-100-18-13	.N.S.L.	194222	IRIVET (PLATE)	9:						••			•	_
	2	38-105-17-13	5340001757604	3422	:RIVET (PLATE)	<u></u>	 55			Ξ.	 FI					
	12	38-105-16-13	N.S.L.	3422	IRIVET (PLATE)	9				=======================================	: INI					
	12	38-105-15-13	IN.S.L.	3422	:RIVET (PLATE)	9:				=======================================	IN I					
	2	50-242	IN.S.L.	••	:PLATE (INGTRUCTION)	=										
	2	50-243	19905004583116	197153	:PLATE (COUNTER)	=	 S				••					
	_	S0-282	IN.S.L.		:PLATE (IDENTIFICATION)	=										_
<b>SI</b>		82-489	15365004876328	:97153		=	 Si									
23		68-647	:5330004563210	197153	:SEAL (GREASE) (DUTER)	==	 S									
SJ /PL	12	195-93	14820002533359	2022	:SAFETY VALVE ASSY (WITH PACKING)	==	 ∰									
		250142	:5360004943024	33525	:SPRING (PUSHER)	==	 ន									
	3	5736-9869	.N.S.L.	33523	:RING (RETAINING)	==										
	2	276375	:N.S.L.	33525	:RETAINER (SPRING)	==										
	2	1216461	N.S.L.	33525	:SPRING (POPPET)	==					••					
	r	1776376	N.S.L.	2525	iPOPPET	==	••					••				
	2	:276373	:N.S.L.	33525	:PISTON	==				 				•••		
		1216462	:N.S.L.	33525	: SPRING (PISTON)	==										
	2	:216372	N.S.L.	33525	:GUIDE (POPPET)	=										
	2	HS28775-012	: 5330005B40265	90696:	:PACKING (BUIDE)	==	 									
	2	HS28775-018	:5330006180799	90696	PACKING (PISTON)	==	 <u>s</u>									
	2	1776574	:N.S.L.	33325	:HOUSING	==										
	3	IN.P.L.	:N.S.L.		:HOUSING & PACKING ASSY (PSEUDO)	æ				₹	A					
	<b>*</b> ::::	1260-812	11620011689325	25472	:HOUSING (OVERSIZE)	==	 83					••				
	*	HS28775-021	5330011602085	90696:	:PACKING (HOUSING)	=	 55									
餌	12	INS16627-1118	:5365002562853	90696;	:RING (RETAINING) (SAFETY VALVE)	==	 55			••		•-				
	:2	H528775-011	:533005822133	90696:	: PACKING (SAFETY VALVE)	:5	 \$5									
	::	300-329-1	11630011084044	197153	: WHEEL HALF ASSY (IN-BOARD)	=		-	-		•	• •				
						•	5	•		-	•					

BLDG 505/507

C-58 MAIN MAEGL

BILL OF MATERIALS

90101A

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	CON LEVEL:	PART MERCE	STOCK	VENDOR	NOYENCLATURE	UNITS!UNIT!YIELD!SCRAP	VIELD SCRA	P 20	UNITS:UNIT:YIELD:SCRAP PART :MIC : REV	EFFECTIVITY: TECH DRD	20 H	PENDING :	PENDING	PENDING
}			5	<b>.</b>		ASSV INEAS		R,D,C;	ינן ומחושבור אבר וכן ו		NUMBER	ACTION :	ACTION :	ACTION
		2391-3CN0285	5340010979226	26344	INSERT (HELTCOIL DUTER) (1ST REP)	<u>s</u>	<u> </u> 	_			<del>-</del> -	;   		
•-		12391-3010254	IN.S.L.		SERT (HELICOIL, INNER) (1ST									
	r:::	HS35914-108	5340010366016	90696	2	9 ARIEA		/	INI:					
		10-114-1	in.s.l.		:MHEEL HALF (INBOARD)									
		: NSZ0364-1032C	:5310002752025	90696	:NUT (NEIGHT)	2 ARIEA :								
		197-74	11630000556302	197155	I NEIGHT (BALANCE) (,0502)	2 PRIES :		_				-		
	:2	187-33	11630008263028	197153	I METGHT (BALANCE) (102)	2 ARIES I		_	: ALT					
	2	HS35207-268	5305009953442	90696	:. SCREW (NEIGHT)	2 ARIES :								
	12	1AM960-13L	15310001670834	¥608	:. MESSER (NEIGHT)	2 AR:EA :								
Ŕ	12	1,72367104	13110002251917	8009	:CIP (BEARING)	1.08:59						•		
	••	38-105-14-13	5220001757605	194222	RIVET (PLATE)	, EA :							-	
		50-242	X.S.L.		PLATE (INSTRUCTION)						<b>.</b> .			
		50-241	311785005000	197151	PLATE (PRINTED)	. ΕΔ :								
	•	20-30	18.8.L.	}		· -		_	•					
3		160 BY	5430001445771	107151	CCA (COCACE) (TAKED)			<i>-</i> -						
8		245-14B	15550001275144	20120		5 5		<b>-</b> -						
3 _		20 CE	7002762000761	270071	LOADING AGEN	5 5		- •				· <b>-</b> ·		
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	-		C7C477700C91	<b>5</b> (4)										
· <b>-</b> .	_	175.20813-1	C7C4777000C91	4670	CAP (WALVE)	5	-		INI:	<b></b>				
!		<u> </u>	12640008105861	79934	:WEVE	 §								
		<u> </u>	.N.S.L.	7887	:.STEM (WALVE)								••	
!	~	1800	13330005797548	73842	I PACKING, O-RING (WALVE)	 §		•						
Ĕ.		HEZ7436-3	12640001166208	7995	:.VALVE ASSY (OVERSIZE)	- <b>3</b>			 F					
		<u> </u>	11650002224525	179934	:.CAP (VALVE)	 55								
		HS20813-1	11650002224525	90696	ICAP (VALVE)	- 25			INI:					
		<u> </u>	12640008105861	7993	:VALVE	 5								
		27	:N.S.L.	7993	ISTEH (WALVE)						•-			
		110-89069H	5220000712204	90696	:PACKING,O-RING (WALVE) (DVERSIZE) 11	<u>ភ</u>				<b></b>				
		HW51102C3-8	:N.S.L.		L.SCREM (DRIVE KEY)									
!	-	HM61102E7-8	2005001595356	80208	1. SCREW (DRIVE KEY)	<u>s</u>			<u> </u>	<b></b>			-	
<b>B</b> .		1170-112	5240004382910	7153	L. DRIVE KEY	ទី (				<b></b>				
		14-13A	BZB1/B4000591:	37133	I.PLUE ASSY	55	••							
ĭ		147-138	ik.S.L.		1PLUG (THERMAL RELIEF)					<b></b>				
	~	1MEZB775-006	13230002920580	9000	1PACKING (THERMAL PLUS) 11	<u></u>		•-						
83		172-283	11630012203847	19153	I.HEAT SHIELD	83				*				
Ĕ	_	:U48743T7	:5310004582846	72962	(TIE)	# # # # # # # # # # # # # # # # # # #								
흕		16710267	5210009045253	2200	(TIE)	118 IEA :			: INT :					
鬞	:	IPIEZZ-720	:5310009481256	2/895	:.NUT (TIE)	. A3: B1			: INI :					
底		:80-513	15310001344152	37153	E)	32 EA :								
ਤ ਤ		:43-761	5305007958694	197153		118 1EA :								
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TITM-TITMIUM
SS-S STI.
SYM-SYNTHETIC
LD-LEAD

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(64024-1	IPOS1)		<u> LA 303</u>	570	<u> </u>	EW 10,41	PR,39	4:35 PM	
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	H.	CONTROL NUMBER		AIRCRA	FT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	6019 FLOW DAYS
DELE		74972A		B-52		BOOSTER ROTARY	1 <i>00</i> 5- <del>0</del> 0-724-2862	28 OCTOBER 86	11W1-3-10-3	
MART	SHEL	74973A				DRIVE ASSY DRUM	1005-00-494-4583	1Ø1D4452	11W1-7-11-3	8
MART	SHEL	74974A	<del>-6</del>	F-4E		UNLOAD UNIT	1005-00-484-2745	175F981	1111-7-11-3	6
<b>1</b> ART	SHEL	74975A	-6	P-52		BOOSTER ASSY	1005-00-300-5135	102450-1	11F46-16-3	8
1ART	SHEL	74976A		A-7		DRIVE ASSY	1005 <del>-00</del> -102-7987	175F7 <b>9</b> 5	11. 15 15 5	_
MART	SHEL	749.77A		F-4		CONTROL UNIT	1005-00-018-0825	AØ5AØØ89-4	1F-4E-2-18	8
MART	SHEL	74978A	-G	F-4C		FEEDER ASSY	1 <i>005-00-</i> 852-1898	175F449	11W1-31-2-2	12
MART	SHEL	74979A		F-4		SWITCH CENTRIFUGE	1005-00-908-3828	822080961	11W1-31-2-2	4
MART	SHEL	74981A				FEEDER DELINKER	1005-00-921-6241	11701120	11W1-7-12-3	5
DELE		74983A	-6			MINI GUN 5.56 MM	1005-00-973-5685	28 OCTOBER 86	11W3-5-5-1-1	
MART	SHEL	7517 <b>5</b> A	<del>-6</del>			LAUNCHER LE-6	1 <del>440-00-</del> 483-5478AA	169695	11L1-3-14-3	20
DELE		751776				LD-5	1 <del>449-99-</del> 673-7278 <del>A</del> A	11 JULY 86	AFLCR 74-2	
MART	SHEL	75225A		F-111		EXIT UNIT SUU-16	1005-00-908-3825	721272761	11W1-31-2-2	19
MART	SHEL	75227A	-6	F-111		DRIVE ASSY SUU-23	1 <i>005-00-</i> 908-3827	822099661	11W1-31-2-2	10
MART	SHEL	75228A		F-111		PANEL ASSY SUU-23	1 <i>005-00-</i> 836-557 <i>0</i>	175F123	11W1-31-2-2	6
HART	SHEL	75229A				GUN MOUNT PALLET ASSY	1 <i>005-00-0</i> 54-3185	9050574	11W1-7-11-3	Ø
MART	SHEL	75231A		F-4		SUU-20 B/A	1 <i>0</i> 95 <del>-00</del> -152-3360	6906070	11829-3-28-1	28
DELE		75232A				FEEDER M2A1	1 <i>005-<del>00</del>-</i> 473-6152	28 OCTOBER 86	11W1-7-9-2	
DELE		75235A		F-111		EXIT UNIT	1 <i>005-<del>00</del>-</i> 111-4648	28 OCTOBER 86	11\1-29-6-2	
MART	SHEL	75236A	<del>-6</del>	F-4		SUU2Ø/A	1095-00-111-4657	SP245-1030	11B29-3-28-1	28
MART	SHEL	75237A		F-4		SUU2Ø	1 <i>0</i> 95 <del>-00</del> -984-1786	5712-503-1	11829-3-28-1	28
fla	L.	75247A				6UN M-39 A/2	1 <i>005-00-5</i> 66-0044	841 <i>0</i> 95 <i>0</i>	11W1-12-3-14	20
34	-	75254A	<del>-6</del>			GUN M39/A3	10 <del>05-00-</del> 93 <del>0-</del> 7787	84365Ø1	11W1-12-3-22	29
. MART	onEL.	75265A		B-52		SWITCH ASSY	1005 <del>-00</del> -733-1301	25-8598	11F8-3 <del>-8</del> -2	8
MART	SHEL	75267A	-6			CYL GAS	1 <i>005-<del>00</del>-</i> 948-5311	11699885	11W1-12-7-2	7
MART	SHEL	75269A		B-52		BOOSTER	1 <i>005-00-</i> 341-8559	199-21 <del>00-</del> 9	11W1-1-3-6-3	7
3LIK		75272A				GAU-5A G	1 <del>005-00-</del> 933-7672	28 OCT 86	11W3-5-5-1	
MART	SHEL	75292A		B-52		BOOSTER	1 <i>005-00-604-02</i> 58	ab <del>a466ab</del> 1	11\1-3-1-1	5
"ART	SHEL	75293A		F-4E		EXIT UNIT	1005-00-934-1432	175F138	11W1-7-11-3	2
CALD		77261A				CAM ASSY	162 <del>0-00</del> -733- <del>0</del> 993	25-4214	451-57-3	421
	POLL	78Ø48A		C-141		DRAG BRACE	162 <del>0-00</del> -943-8754	3F31 <del>96</del> 4-119	4SA6-19-3	Ø
FRED	FRED	7958ØA		4.45		PYRO TECHNIC PISTOL	1 <i>0</i> 95- <i>00</i> -726-5657	7265657	11W2-9-2-31&34	
	SHELL	81466A	<del></del>	A-10		GAU-8 DRUM ASSY	1005-01-234-0764	218F5#4	11W1-7-14-3	29
COOP	CUUP	83317A		F-16		DRAG BRACE ASSY	1620-01-162-7542	2666566-111	4S2 <del>-8Ø-</del> 13	30
MART	SHEL			A-10		GAU-8 SCOOP DISC.	1005-01-234-0762	218F385	11W1-7-14-3	19 .
RIGB	RIGB			F-4 M		PRESSURE PLATE	163 <i>0-00</i> -498-3225	5000254	481-2-1093	16
JENS	RIGB		<b>ب</b> بند	F-16 H		BRAKE ASSY	1639-91-292-6584	50072714	4B1-2-1163	38
SENT COOR		98181A		C-58		WHEEL ASSY	1639-91-182-6267	3-1268-3	4H1-4-493	29
COOP NAPT		98488A		B52		LINK IN BOARD	162 <del>9-99</del> -699-9886	25-4211	4\$1-57-3	48
HART		94118A 97414A		A-10 E-14 M		GAU-8 DRUM ASSY	1005-01-234-0763	218F966	11W1-7-14-3	29
RIGB		99020A		F-16 M		HEAT STACK HEAT STACK	1630-01-252-4702	8631424-30	481-2-1163	26
.1109	וועטטווו	1104011		F-16 M		NEM SINGS	1630-01-252-4703	8631424-19	481-2-1163	20

## C-5 MAIN WHEEL

WHEEL ASSY PCN 90101A WCD 21101N

WHEEL HALF INBOARD PCN 90101A WCD 21103N

1 1

WHEEL HALF OUTBOARD PCN 90101A WCD 21104N



WCD Ellei N Assy/ Dishssy

OP# IN-

OP# OIB

OP# DZC DISASSY HALVES

WCD# 21104 N OUTER

OP# 006
REMOVE CUP FROM
WHEEL HALF

OP#OOGA
LINE TRANSFER
CONY -> CRANE

OP#OO7 CHEM. CLEAN WCO# 21103 N INNER

OP[±]006 REMOVE CUP FROM WHEEL HALF

OP# OOGA

LINE TRANSFER

CONV. -> CRANE

OP#OO7 CHEM. CLEAN OF CCA BLAST CLEAN

OF#OCE BIRST CLEAN

OP" OH ANDDIZE STRIP

OP[±] 009 REMIYE EFILEN SCREWS

OP#015 & 015A F.P.I.

OP#O10 E.O.M. BROKEN TAPS \$ SCREWS

OF# 19 NICK & BURR

OPTOIL ANODIZE STRIP

0P#030 E \$ I & ROUTE

OP#015 & Q5A F.P.I.

OP#040 THREADED INSERT REPAIR

OP#019 NICK & BURR

OP#043
REMOVE BROKEN
SCREWS

OP#030 EdI & ROUTE

OP#045 SAFETY VALVE HOLE REPAIR

OP#044
POLISH OR MACHINE
BASE OF DRIVE
KEY BOSS

OP#048 VALVE STEM HOLE REPAIR

OP#045
REMOVE HELICOILS

OP#OSS BEARING BORE REFAIR SPÉRCO RETAINET SPATE REPAIR

OP[±]058 BEARING BORE SEAT REPAIR

OF#OSS BEATING BOTE REFAIR

OP# 060 SHOT PEEN OP[#]OS7 BEIRING BOBE SEAT REPAIR

OP # 70A, 70B, 70C, 70D 7 70E, 70F, 70G, 70H, ANODIZE 70I, 70I, 70K, 70L

OP 59 BEARING & SEAL GROOVE REPAIR

OP#OTZ INSTALL CUP INTO BEARING BORE

OP#060 SHOT PEEN

OP#074 MACHINE O.D. OF CUP & BUSHING ASSY

ANODIZE { OP* 70 A, 70 B, 70 C, 70 D, 70 F, 70 F, 70 G, 70 H, 70 F, 70 K, 70 L.

OP#O76
INSTALL CUP & BUSHING
INTO BEARING BORE

OP#073 INSTALL CUP INTO BEARING BORE

OP# 077
INSTALL CUP INTO BEARING
BORE & SEAL BUSHING

OP 074 MACHINE O.O. OF BUSHING & CUP ASSY OP# CT& MACHINE CL OF COP A KILMING NESY

OF#079
INSTALL BUSHING & CUP
ASSY INTO BEARING
BORE

OP# 080 INSTALL INSERTS

OP#095 MOVE TO PRE-FINAL INSP & ASSY & LOAD ROLLER CONV.

OP#098 RAKE INSTALLATION

OP#098A UNLOAD ROLLER CONV.

CP#100 LOAD OVERHEAD ONV.

> OP#100A WASH

OF#ICC B MASK OP OTS INSTALL CUP & BUSING ASSY

OF # 077
INSTALL CUP INTO
BEARING BORE & SEAL
BUSHING

OP^{±L}O78 MACHINE O.O. OF COP & BUSHING ASSY

OP# 079
INSTALL COP &
BUSINING ASSY

OP# 000 INSTALL AFLICOUS

OP#095 MOVE TO PRE-FINAL INSP & ASSY & LOND ROLLER CONV.

AP OPB RAKE INSTALLATION

OP#O98A UNLOAD BOLLER CONV.

Op#	100 C
PRIM	

LIAO CIENTES CON.

OPTI	000
DRY	/

CF 100A WASH

OP# 100 B MASK

OP#180C PRIME

OP# 100G

OP# NO D

## OP# 100 H STRIP

OP#100 E 1ST PAINT

OP#106I UNLOAD OVERHEAD CONV.

OP#100 F ZND PAINT

OP# 110
INSTALL SAFET!
VALVE

07100G

OP#120 TEST SAFETY VALVE OP#IGOH STRIP

OP[#]IOOT UNLOAD OVERHEAD CONV. BALANCE BALANCE

OF 125 BALAINCE

OPTI30
INSTALL SEIN
A RETAINERS
FINAL INSP.

OF 130 NSTALL SEALS * RETAINERS FINAL INSP

WCD# ZIIOIN ASSY/DISASSY

OP#10 MATCH-UP

OP#20 ASSY WHEEL HALVES

OP# 30 TOUCH-UP PAINT

OP 40 FINAL ACCEPT.

OP# 50 FINAL PROD. VISUAL OP# 9999 SELL

JOB ORDE	R NO 3 Q	UANTITY		4 PRODUCTION		DATE SCHED		DATE COMP	LETED
PART NU	MBER	<del></del>	8. TECH	4W-1	-61 4-493			9. ITEM SER	IAL NO.
-5 MA	ESIGN-SERIES IN	11 STOCK	NUMBER	1 000	12 OPTIO	NAL		1	
. SERIAL I	NUMBER	14 NOUN WHEEL	. ASSE	MBL.Y	901	OI A	728	99A	
SPATCH	16. PERF RCC/OP NO	17.		ORK TO BE ACCO	MPLISHED C/N		18. MECHANIC	19. p.··	20. ''Q''
P/N G9400 -1268	0-117C 2		00118	26267 9	0101A 2899A				
				TRECTIVES	MANO	R 66-51 I 66-3			
		PROCES	SES S	PECIFIED HOROUGHLY	IN THIS	DOCUMEN AND AR	<u>.</u>		
		PRACTI THE BA	CES A	TH ALL PE ND HAZARD ECHNICAL	S CONTA ORDER A	INED IN ND T.O.			
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		STAMP.							
	*REQD*	3-1268 4G9400		C					
I. FINA		TIONAL A		COORDINATION/IN	ITIATING RC	SIGNATURE/D	ATE	23. DOCU	MENT/SN
			·····						

JOB ORD	ER NO 3 QU	JANTITY	4 PRODU	CTION SEC/RCC	5 DATE SCHED		DATE COMP	LETED
. PART NU	MBER		8 TECH DATA				9. ITEM SER	IAL NO.
MODEL-	DESIGN-SERIES	11 STOCK	UMBER	12 'OPT	ONAL		<del>i</del>	<del></del>
3. SERIAL	NUMBER	MHEEL	ASSEMBLY					
S. DISPATCH STATION	16. PERF RCC/OP NO.	17.	WORK TO BE	ACCOMPLISHED		18. MECHANIC	19. p	20. q
3	010		*MAT	CH-UP*	-		001 MM	
	*REQD*		ROUTED	COMPONENT	j	1	002 07 003 MU	<b>\$</b> 2
<del></del>	<b> </b>		RVICEABLE HALF SUBASS	REWORK	NO REWOR	1	<u> </u>	<u> </u>
		21103N	HALF SUBASS					
3	020	ASSEMB	LE	漆	CZP MOVE*		001 MN	5
	*REQD*						002 07 003 WA	
3	030	FINAL.	TOUCH-UP PA	IINI *	CZP MOVE*		001 MN	पंच म
	*REQD*						002 09 003 TU	<b>\$</b>
3	040	1	ACCEPTANCE			1	ততঃ ক্রম	GP
	*REQU*	ľ	NT FOR COMP PRECEDING			1	002 09 003 TU	4
.3	050	FINAL	PRODUCT VIS		CTION CZP MOVE*		001 MN	
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			···					
1. FINA	H FUNCT	I 2:	. COORDINAT	CON/INITIATING	CC SIGNATURE/	DATE	<del></del>	MENT/SH
							2110	1. N

2 JOB ORDE	R NO 3. QU	JANTITY	4 PROI	DUCTION SEC/RCC 5	DATE SCHED	PAGE_OF	
				MME GM		0.000	
7 PART NUN	IBER		8 TECH DATA		<u> </u>	9. ITEM SE	RIAL NO
				4U-1-61 4U1-4-493	·		•
O-5 MAI	ESIGN-SERIES	11 STOCK	NUMBER	12 OPTION	_		
				72	899 A	90101A	1
13. SERIAL Î	IUMBER	WHEEL	HALF - IN	INER			; 7 3
DISPATCH	16. PERF RCC/OP	17.			18.	19.	20
PZN	NO.		NSN	C/N	MECH	ANIC "P"	o
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		GOVERN FPI	ING DIRECT	TIVES: AFLCR MANOI IAW MIL-ST	4		
		SHOT P ANODIZ		IAW MIL-S-	13165		-
			***2014-T	S ALUMINUM#			
		PROCES	SES SPECIF	NVOLVED IN THE FIED IN THIS I JGHLY TRAINED	DOCUMENT		
		FAMILI	AR WITH AL	L PERTINENT	SAFETY		-
				AZARDS CONTAII ICAL ORDER (T			
		T.O. S	UPPLEMENTS	REFERENCED.	THE		-
		WILL A	LWAYS BE L	S AND SUPPLE USED IN CONJU	1		
			HIS DOCUME NENTS WILL	ENT. _ BE THOROUGH	LY_		
				TED (C/P MOV PERATIONS/DIS			
		STATIO		EKHITOKOVNIDA	THIUM		
		MANU C		ARNING			
				LOWING REPAIR TRE THE USE O			
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				FIALLY DANGER DATE SAFEGUAR			
		PRECAU PRECLU	TIONS MUST DE INJURIE	T BE EMPLOYED	1		
21. FINA	L DESTINATION		NTINUED)	ATION/INITIATING RCC	BIGNATURE/DATE	23. DOC	UMENT/SN
DISPATO		IONAL A		c		2110	H MEC
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PART NU	MBER	B TE	CH DATA		- <del></del>		9. ITEM SERI	AL NO
							J. ITEM SER.	~
O MODEL F	SECON CERIES	III STOCK NUMBER		112 OPTION		·		
O MODELLE	COION SERIES	I STOCK NOMBER	•	TIZ OFTION	100			
3. SERIAL I	NIIMBED	14 NOUN	······································	4				
S. SENIAL	NOMBER		F - INNER					:
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DISPATCH STATION	PERF RCC/OP		WORK TO BE ACCOM	PLISHED		MECHANIC	p	20. ''Q''
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34II	005	DISASSEMBL	E	*:07	P MOVE*		001 MNS	r IGW
Andrew San San	See Mark Company		. •		11007100		002 02	
	*REQU*						OOS WIN	)3
340	006	REMOVE CUP	FROM WHEEL	. HALF	·		001 MNH	15W
	*REQD*			*C/	P MOVE*		002 02 003 WD	) C
34C	007	CHEM CLEAR		*0,7	P MOVE*		001 MNF	GW
	*REQD*						003 AC	2
34B	008	BLAST CLEA	N .	*C.	TP MOVE		001 MNF	ម្រុស
	008			,			002 03	,
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59	009	REMOVE BRO	KEN SCREWS	*07	T MOVE		001 MNF	RA
	1.0						002 01 003 BE	31
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5 <b>8</b>	010	EDM BROKEN	SCREWS &	APS *C	√P MOVE*		001 MNF	MG
	.04						003 ME	0
34C	011	ANODIZE ST	919		P MOVE*		001 MNF	160
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<b>发生</b>				#Ę,,	P MUVE.*		OOT WH	NA -
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DISPATO	L DESTINATION		COORDINATION/IN	TIATING RCC	SIGNATURE/D	ATE	23. DOCU	MENT/SN
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PART NU	MBER		8 TECH DATA	· <del></del>			9. ITEM SER	AL NO.
MODEL-	DESIGN-SERIES	11 STOCK	NUMBER	12 OPTIONAL				<u> </u>
3 SERIAL								
S. SEMIAL	NUMBER	WHEEL	. HALF - INNER					
S. DISPATCH	16. PERF RCC/OP	17.			1	3.	19.	20.
STATION 4E	019	NICK A	WORK TO BE ACCO	MPLISHED *C/P		IECHANIC	ं••• 001 माना	<b>o</b>
ก (จังเรีย	*REQD*						002 04 003 NB	) <b>4</b>
3.4 E.	030	E & I	AND ROUTE	*CZP	MOVE:*		001 MNI	16 W
-	*REQD*						002 04 003 EI	2
.9	044		POLISH OR MAC			<u></u>	001 MN	RA -
•	.34		KEY BOSS IAW 1 DEEP BY 2.5 IN 1		RMS		002 01 003 BE	- 1-1.
<i>s</i> 9	045		HELICOILS	*C\P			OOT MN	RA
•	*REQD*						002 01 003 BE	) ) 1
<del>(Ÿ</del>	050		IER GROOVE REP			•	001 MN	RA
•	.02	PARA .	) (2)	*C/P i	MOVE*		002 61  003 MV: 	14
, <del>9</del>	056		G BORE REPAIR	(INBOARD) *C/P	IAW		001 MN	RA
•	.01	FIG 5-	)	··· [-/ [- ]	MOVE."	_	002 01 003 MV	4
ŚŸ	057	BEARIN	IG BURE SEAT R	EPAIR (INBU *C/P			001 MN	RA
<b>,</b>	.01			"L,/P	MOVE T		002 01 003 MV	4
59	059		NG AND SEAL GR				001 MNI	RA
,	.01	1 TO 5	-6 & 57	#C/P	muve*		002 01 003 MV	4
. 6	080		YEEN MIL-S-IJA				001 MN	RC
i	*REQU*		O .012 A2 SHOT COVERAGE	*CZP			002 01 003 SP	1.
26	070	ANUU.I.Z	L TYPE II CLA	58 I *UZP	MOVE:		001 -MR	
	*REQD*						002 03 003 AS	
	AL DESTINATION			INITIATING RCC SIG	NATURE/DAT	<u> </u>	23. DOCU	MENT/SN
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PART NU	MBER		8 TECH	DATA		<del>-</del>		9. ITEM SE	RIAL NO.
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SERIAL	NUMBER	WHEE		- INNER					
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7	074	MACH:	NE O.D	OF BUSHI	NG AND	_ <del>`</del>			<del> </del>
	,01	LUP	abbembl	Y (1ST) R C	NOVE				
7	075			AND BUSH				001 M	
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7	078	MACH:	INE O.I	. OF BUSH			1	001 Mi	
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7	079	1		AND BUSH			<del> </del>	001 M	
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<del>y</del>	080	-I		ICOILS 10		JIREMENT C/P MOVE:		001 M	
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3	100	PAIN	<u> </u>		*(	CAL MODE:	2	001 M	
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PART NU	MBER	<u>.</u>	8 TECH C	DATA	····				9. ITEM	SERI	AL NO
MODEL	DESIGN-SERIES	III STOCK N	UMBER		12 'OPTI	ONAL	<del></del>				
SERIAL	NUMBER	WHEEL	HALF	- INNER	_						
ISPATCH STATION	16. PERF RCC/OP NO.	17.	wo	RK TO BE ACCO	MPLISHED			18.	19. p	,	20. a
3	122	BALANC				37P P	10VE#	MECHANIC	001	লম্য	_
	*REQD*								002		)1
3	123	INSTAL	L SEAL	S AND RE					001		GP
	*REQD*				: <b>+</b> : ₁	C/P N	10VE*		002		3
3	1.25			ANCE OF					001		GP
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3	130	FINAL	PRODUC	TION VIS				<u>-</u>	001		'GP
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JOB ORDE	R NO 3	QUANTITY	4 PRODUCTIO	1	DATE SCHED	-	DATE COMPL	ETED
PART NUI	MBER		8 TECH DATA	1-61			9. ITEM SERI	AL NO.
O MODEL-D D-5 MAI		S II STOCK		12 OPTION	IAL			· · · · · · · · · · · · · · · · · · ·
3. SERIAL I	NUMBER	MHEEL	. HALF - OUTER	901	DIA	728	799 A	
STATION	16. PERF RCC/C NO.	WORK TO BE ACCOMPLISHED				18. MECHANIC	19. p.·	20. ''q''
PZN 300-328 300-328		)	NSN 30011084043 S 30011084043 S					
		4	**** UNIT COST VING DIRECTIVES	3: AFLCR	46-51	:		
		FPI SHOT F		WIL-ST				
		ALL PE	****2014-T6 A	ALUMINUM* VED IN TH	·*******	:		
		HAVE I	BSES SPECIFIED BEEN THOROUGHLY TAR WITH ALL PE	Y TRAINED ERTINENT	AND ARE SAFETY			
		THE BA	ICES AND HAZARI ASIC TECHNICAL SUPPLEMENTS REF	1				
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		CLEANE MOVES	ONENTS WILL BE ED & PROTECTED BETWEEN OPERA	·				
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			JURES REQUIRE THE TENT, PROCESSES ARE POTENTIAL	S & CHEMI LY DANGER	CALS DUS TO			·
		PRECAU PRECLU	NEL. ADEQUATE JTIONS MUST BE JDE INJURIES.	EMPLOYED	TO TO	<u> </u>		
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O MODEL-DESIGN-SERIES 11 STOCK NUMBER   12 OPTIONAL   12 OPTIONAL   13 SERIAL NUMBER   14 NOUN   WHEEL HALF - DUTER   15 OPTIONAL   16 OPTIONAL   16 OPTIONAL   16 OPTIONAL   17 OPTIONAL   17 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONAL   18 OPTIONA	Z JOB ORDE	ER NO	3 QUANTITY	,	4 PRODUCT:	IN SECFRCC	5 DATE	SCHED	6	DATE COMP	LETED
12   NOUN   WHEEL   HALF - DUTER   18   18   19   10   10   10   10   10   10   10	7. PART NU	MBER		8 TEC	CH DATA		<u></u> .	<u> </u>		9. ITEM SER	AL NO.
12   NOUN   WHEEL   HALF - DUTER   18   18   19   10   10   10   10   10   10   10											
### DOTES   16.   16.   17.	O MODEL-D	ESIGNISI	RIES 11 STO	OCK NUMBER		12 'OPTI	ONAL		-	<del></del>	· · ·
15.   16.   17.   18.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.   19.	3. SERIAL I	NUMBER	14 NO	ŪN		_					
DISPATION   PERF NOCION   WORK TO BE ACCOMPLISHED   WECHANIC   TO			WHI	EEL HAL	F - OUTER						
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MANPROTICE T 1 PATE 88237 1 PAGE __ OF__ 1140.c 21104N WORK CONTROL DOCUMENT (MEDS) 6 DATE COMPLETE 2 JOB ORDER NO 14 PRODUCTION SECIRCO 5 DATE SCHED MNPGW 90101A 7 PART NUMBER 300-328-1 4W1-4-493 TO MODEL DESIGN SERIES | 11 STOCK NUMBER 12 OPTIONAL C SB MAIN 1630011084043 13 SERIAL NUMBER 14 NOUN WHEEL HALF - OUTER E29266 19 Zυ DISPATCH PERF RCC OP WORK TO BE ACCOMPLISHED MECHANIC \$672 ******* ***************** UNIT COST: GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 IAW MIL-STD-6866 SHOT PEEN IAW MIL-S-13165 IAW ANODIZE MIL-A-8625 **ALUMINUM******** **************2014-T6 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP . 001 300-328-1 COORDINATION/INITIATING RCC SIGNATUPE/DATE FINAL DESTINATION DOCUMENT/SM DISPATCH FUNCTIONAL " Thomas W. hilden CODE

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7	043	SHIETT VHEVE TO	Jem 1121		MOVE.*			
39	048	VALVE STEM HOLE	REPAIR I	AW			M	1
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59	055	BEARING BORE RE	EPAIR (OUT	BOARD	) IAW		i	!
		FIG 5-5, 5-6, 5	5-7	*C/P	MOVE*			
59	058	BEARING BORE SE	EAT REPAIR					!
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23	060	SHOT PEEN MIL-	5-13165 IN	TENSI	TY OF	MAD S	2 3 1989	<del></del>
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26	070	ANODIZE TYPE I	I	*C/P	MOVE*7	~\o\		i
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69	072	INSTALL CUP IN BUSHING (1ST R			MOVE*		М	
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69	074	MACHINE O.D. O	F BUSHING			-	M	<del></del>
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59	078	MACHINE O.D. OF BUSHING				   M	
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59	079	INSTALL BUSHING AND CUP		-Y		M	 
		INTO BEARING BORE (2ND )	REPAIR)	10VE*	gg/% Leghan (* 1. * )		
59	080	P/N N.P.L. INSTALL INSERTS IAW PAGE	6-1 PA	ARA	<u></u>	\ \ \ \	!
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13	098	RACE INSTALLATION	*C/P M				<u> </u>
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3	100	PAINT	*6/5 %	1	1000	M	
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13	110	INSTALL SAFETY VALVE	#C/P M	IUVE*	6		
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26	070	ANODIZE	TYPE II	CLASS	1 *C/P	MOVE	, *3	1365 AND 1365		<b>—</b> .
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59	059	DEARING FIG 5-6	AND SEAL	. <u>GROO</u> V		R IAW MOVE*		M		—[3
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59	057	BEARING	BORE SEA	T REPA				<u>                                   </u>	•	
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DISPATCH STATION 34E	PERF RCC/OP NO	E & I A	WORK TO E	BE ACCOMPL		MOVE	MECHANIC	<b>b</b>	o	<u>_</u> ;
3.	16.	17.	<del></del>			<del></del> -	18.	19.	20.	<b>-</b>
3. SERIAL N	UMBER	WHEEL	HALF - IN	NER						<u> </u>
O MODEL-D	ESIGN-SERIES	II STOCK N	JMBER		12 'OPTIONAL					<b>-</b> `
7. PART NUM	BER		8 TECH DATA					9. ITEM SERI	AL NO.	<del>-</del> .

2 JCB ORD	ER NO  3. Q	JANTITY 4 PRODUCTION SECIRCO   5 DATE SO	нер ј	6. DATE COMPLETED
7. PART NU	MBER	8 TECH DATA	<u> </u>	19. ITEM SERIAL NO.
O MODEL	DESIGNISERIES	11 STOCK NUMBER   12 OPTIONAL	···	
3. SERIAL	NUMBER	14 NOUN		
		WHEEL HALF - INNER		-
S. DISPATCH	16. PERF RCC/OP	17.	18.	19. 20.
STATION	NO	WORK TO BE ACCOMPLISHED P/N 63631152 C/F MOVE	MECHANIC	
		0,1 110 2		
	-			
59	074	MACHINE O.D OF BUSHING AND		<del>                                     </del>
		CUP ASSEMBLY (1ST) REPAIR		
		C/P MOVE		
9	075	INSTALL CUP AND BUSHING ASSEMBLY		M
		INTO BEARING BORE (1ST REPAIR)  *C/P MOV	E*	
		P/N N.P.L.	-	
59	077	INSTALL CUP INTO BEARING BORE AND		M
		SEAL BUSHING (2ND REPAIR)*C/P MOV P/N LM236710A	£ *	
		P/N 66C330D1-121		
9	078	MACHINE O.D. OF BUSHING AND CUP A (2ND REPAIR) *C/P MOV		M
		(ZND REPAIR)		
	8.77			
9	079	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (2ND REPAIR).		M
		*C/P MOV	E*	
59	1 080	P/N N.P.L. INSTALL HELICOILS 100% REQUIREMEN		
		*C/P MOV	1 11 11 11 11	70207
	*REQD*		APR	L
<b>(3</b> ,)	095	PRE-FINAL INSPECTION AND ASSEMBLE		5.1989
	*REQD*	*C/P MOV	E*   10\0	
	KEQD.	10 4 APR 1989	***	
. 3	090	RACE INSTALLATION *C/P MOV	E*	n
	KEB	P/N LM236710A 1980	7080	SMAN (A)
			· ·	1.771
. >	100	PAIRI COP MOV		1000il
	*REQD*	트레 APR 1989	70725	70725
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', PART NUM		8 TECH DATA				9. ITEM SER	15L NO.
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TO MODEL-S	ESIGN-SERIES	II STOCK NUMBER	12 OPTIONA		<u></u>		-
13. SERIAL		14 NOUN					
IS. SERIAL	NUMBER	WHEEL HALF - 1	INNER				-
DISPATCH	16. PERF RCC/OP NO	17.	D BS ACCOMPLISHED	18.	CHANIC	19.	20.
TATION 13	122	BALANCE	BE ACCOMPLISHED *C/F	MOVE	O)	m	
	*REQD*	<b>A</b> P	R 0 4 1955		101901	70	
13	123	INSTALL SEALS A		MOVE*	^	ri ·	<del>                                     </del>
	*REQD*	**	APRO4 TETS	MOVE		No.	-
13	125	FINAL ACCEPTANCE DOCUMENT FOR CO			Ç,	1	
		OF ALL PRECEDIN	IG OPERATIONS A	155 958		71152	-
13	1.30	FINAL PRODUCTIO		MOVE*		5115.2.	-
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21. FINA	L DESTINATION	22. COORD	INATION/INITIATING RCC S	GNATURE/DATE		23. DOCU	MENT/SN

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<b>(</b> )	0020 E 0030 E 0040 E	RWB-AW-K2 9.00 RWB-AW-T1 4.00	INSTL SEGMENTED HEAT SHIEL INSTL BRAKE KEY/MULTI-SCR. INSTL UNDESTRUCTED TIE BOLL DATE:	 Ew _T		.02429	2 5	.029 .179 .047	
9	0000 E 0000 20 HY 0000 3000	RJP-PW-R1 1.00 25 1.00	REM RPL PAPRWRK SIGN OFF : LLOYD A.HARGIS MANEL 7335:	LABOR STANDARDS HISTOR	RY	.0100; .000	.000	.012	0

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9	0030 N 0040 E RJF-PW-R1 9000 YH 01 25 0900	1.00 1.00 REM RPL PAPRWRK SIGN OFF 1.00 LLOYD A.HARGIS MANEL 733	LABOR STANDARDS HISTORY	.01700 .01001 .000 .000	.020 .012 .000 0

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	FEDERALE DE LA PARENTE TREMELLE DE DIVINI E PETE TREMELLE DE DIVINI DE LEMENT		BESFIFTION BIFFLEMENTAL	BHBL TIME -	870 - A FBURB - BLY FOT D
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೦	0050 E RWE-BH-W1 0040 E RWE-SD-P3 0050 E RWE-SD-P3 0060 E RJP-FW-R1	1.00 PNT WHL HALF-ZINC CHRCMA 1.00 PNT WHL HALF (2ND CCAT)	POLY 2 COATS	.01335 .11574 .10214 .01001	.144 .127 .012
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	FB103 B E YH EA		FERCENT ENGS 99.9	CSB MAIN WHEEL INNER	.41		.4:	
0	001 YH 01 0010	00 1.00	700.705 / //704	PART NUMBER/NSN	.000	.000	.000	Ç
		51 1 30	300-329-1	PREINSPECTION WHEEL HALF	015	665	.019	£
~	0010 E	5W5-JF-W2 1.00	PREP TO ASSY OR DISSY WHEEL	to a boom de l'Aller a company a de sell Aller Elle Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de l'Aller Assessment de	.00442		.005	₹
<b>(3)</b>	0020 E	KAL-30-45 1.00			.00115			
	0030 E	RJP-PW-R1 1.00	REM RPL PAFRWRK SIGN OFF DOC		.01001		.012	
<b>(3)</b>	0093 YH 01	21 1.00	)	RACE INSTALLATION WHL/HALF	.178	.037	.216	51
620			INSTALL BEARING CUPS		.16838			
			REM RPL PAPRWRK SIGN OFF DOC	BALANCE WHEEL HALF	.01001		.012	
()		21 1.00						32
<b>C</b> >			REM NONTHREADED PLASTIC PLUG		.00339		.016	
	0020 E	6MC-MT-D1 1.00	REMOVE MASKING TAPE	•	.00191			
2	0030 E	RWE-UH-WZ 1.00	REMV WHL HLF F/PAINT CONVYOR BALANCE WHEEL HALF		.00833		.010	
	0040 E 0050 E	00.1 10-EE-GWN	DEM DOL DADOMOV CICAL GET DAC	•	.07734			
_	3 0000 10 HV 7510	21 1.00	REM RPL PAPRWRK SIGN OFF DOC	INSTALL SEALS & RETAINERS				12
<b>3</b>			Insti bearng/snap rng securd		.02459		.029	**
			INSTL TIRE CHANGE DATA PLATE		.00692			
<b>4</b> 0.			REM RPL PAPRWAK SIGN OFF DOC		.01001		.012	
<b>3</b>		21 .01		LABOR STANDARD HISTORY	.000	.000		ø
	0010		OSFEB85 NEW REQUIREMENT/INIT					
£ (5)	0011		7MAR86 CHANGED SKILL CODE FR	OM YG TO YH				
90)	0012		NO TIME CHANGE					
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	0100 35 01 3	<b>1.00</b>		PAINT WHEEL			.067		4.0 100
(1)	*****	GPL-PA-01 4.00 I				.00093		.004	
V.7	****		ask & UNMASK MEDIU	***		.01242		.015	
	****		ANG WHL HLF ON PAI			.02336		.029	
<u></u>			NT WHL HALF-ZING C			.11574		. 144	
٠.3	11.00 0		VT WHL HALF (2ND C	- · · · · · · · - · · · · -		.10214		.127	
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*		-5 M WHL ABBY	•	ROD MNFBF 4W1-4-49	<del>.</del>	Ξ	71 <b>2</b> 5	
		F FF A/R REV	530	BERGETTEN				
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	0005 VU 01	21	1.00	בסבווויסבבריוטיו החבבו חסוב	.015	.003	.019	2
9	0010 E	RWB-JF-W2	1.00 PREP TO ASSY OR DISSY &	WHEEL	.00442		.005	
-	002 <b>0</b> E	KAL-63-46	1.00 INSPECT VISUAL	•	.00115		.001	
	0030 E	RJF-FW-R1	1.00 REM RPL PAPRWRK SIGN OF		.01001		.012	
9	0098 Yh 01		1.00	RACE INSTALLATION WHL/HALF	.178	.037	.216	27
129	0010 E	RWB-BC-03					.203	
	0020 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OF	FF DOC	.01001		.012	
15.00	0110 YH 01	21	1.00	FF DOC INSTALL SAFETY VALVE	.260	.055	.315	37
النه	0010 N		1.00	INSTALL SAFETY VALVE	.25000		.302	
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3)	0120 YH 01	21	1.00	TEST SAFETY VALVE TEST SAFETY VALVE FF DOC BALANCE WHEEL HALF	.060	.013	.073	9
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ا چن	0122 YH 01	21	1.00	FF DOC  BALANCE WHEEL HALF C PLUG  ONVYOR  FF DOC  THISTALL SEALS & RETAINEDS	.111	.023	.134	17
ويويده وا	0010 E	GPL-PD-01	4.00 REM NUNTHREADED PLASTIC	C PLUG	.00339		.016	
	0020 E	GMC-MT-D1	1.00 REMOVE MASKING TAPE		.00191		.002	
	0030 E	RWB-CH-W2	1.00 REMV WHL HLF F/PAINT CO	ONVYOR	.00833		.010	
E	0040 E	RWB-89-01	1.00 BALANCE WHEEL HALF		.07734		.093	
	0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN D	FF DOC	.01001		.012	
~	0123 YH 01	21	1.00	INSTALL SEALS & RETAINERS	.041	.009	.050	6
<u></u>	0010 E	RWB-AW-B1	1.00 INSTL BEARNG/SNAP RNG	SECURD	.02459		.029	
	0020 E	RWB-AW-81	1.00 INSTL TIRE CHANGE DATA	PLATE	.00572		.002	
	0030 E		1.00 REM RPL PAPRWRK SIGN C		.01001		.012	
<b>(9</b>	9000 YH 01	00	.00	LABOR STANDED HISTORY	.000	.000	.000	0
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6	0040 38 0 0010 N 0020 E	01 25 1.00 1.00 SJP-F9-35 1.00	FINAL	CEPTANCE OF W.C.D.	.132 .033 .08000 .05255	.165 40 .100 .065
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-· <b>、</b>		-5 * WHI ASSA		500	MNPRA 481-4-480		3	7193	
	CRES TECH S B W	F FF 4/F REV							
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	STEP DIL K	E DO ELEMENT	FACT	STORED	RIFTIEN> SUPPLEMENTAL	HOURS	TIME	HOURS	DLY FOT O
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	0001 VB 01 A616	√V	1.00	700-700-1 1470	FRAT NUCZENZINON	.000	.000	.000	Ō.
	0000 10 01	15	۸۳	1500	ANILOGADAA - BEMADI BEAREN GREENS	255	662	A+#	•
_	0007 GR VI	8884-884-81	.03 50	S/II FOR BENCH WORK GENERA	PRARATE 2 PARTS	.233 7757	.002 5	(50 (50	•
	0070 E	75-35-43	1.00	PREP HAND DRILL FOR HEE	THORRIE 2 TENTO	0054	.1	.009	
	0070 F	AT: -85-41	7.00	DATE & FASYOUT SOR TO 251	IN2 SCREWS IA2 HOLES ICC POLISH BASE DRV KEY HOLES	0754	.0	.053	
-40	0000 E 0040 E	STI -TH-A1	2.00	TAP HOLE TO 0 25 IN THEN DI	1A2 HOLES	0147	7	.032	
(3)	0050 E	012 1.1 A1	1 00	REM RPI PAPRIERY STEN FIET TO	r reced	0100	.,	.011	
	10 45. 4400	15	1.00	TELLING THE THE TOTAL OF THE TELLING	SULTSH BASE ABOUKEY HULES	300	045	.345	16
	0044 OA 01 0010 F	RRW-5! I-61	.50	SZIL FOR BENCH WORK GENERAL	POLISH BASE DRV KEY HOLES PRO RATE 2 PARTS PREP TO POLISH BASE HOLES POLISH BASE HOLES  C REMOVE INSERTS PRO RATE 2 PARTS AS 8 DCCUR AS A	. 2753	5	.158	10
3	0070 E	796-39-91	1 00	or of the perior work designing	PREP TO POLICE BASE HOLES	0045	5	.005	
	070 E	844-86-52	9.00		POLICH RASE HOLES	0155	2	.163	
_	0050 F	GC1 -C4-44	4.00	CLEAN RETNO HOLE WITH ATR	) DEIGH PROC HOLLO	.0012	4	.005	
<b>?</b>	0040 E	8.10_0 <u>ki_</u> p(	1 00	BEM BBI BABBABK SIEW UEE DE	r	0100	it	.011	
	0000 E	15	1.00	HEIT HE I PERMIT OF OUR OF DE	DEMINIE INGESTS	174	027	.203	9
	0010 F	RBW-SI-61	-50	S/II FOR BENCH WORK GENERAL	PRO RATE 2 PARTS	. 2752	5	.158	,
3	0070 E	31 R-45-DB	1.00	EMUF SMALL SPRING W/TWEETER	rs a name	0123		.014	
	0030 F	GTI -TH-A1	1 00	TAP HA! F TO A 25 IN THEN DI	'A	0147	7	.014	
	0040 E	KTI -TT-03	1.00	TAP FACH ADDITIONAL THREAD	,n	0017	in	.001	
£1.5	0050 F	601 -04-44	1.00	CLEAN REIND HOLE WITH AIR		.0017	4	.001	
	0060 F	RJP-PM-R1	1.00	REM RPI PAPRWRK SIGN OFF NO	ar.	-0100	11	.011	
	0050 JA 01	15	.07	TELL TO ELL TITO CONTROL OF THE	O/S HOLE ON MILL/MED PART	235	- 009	.067	3
0	0010 F	RMI -SII-V2	. 25	S/II VEST MILL RORE LEG FIXE	RPRORATE OVER 4 PARTS	-8016	7	.230	· ·
	0020 F	RM: -HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAN	P	. 1577	'A	.181	
	0070 5	RM -AL-AB	1.00	ALIEN VERTICAL AXIS ROD	p	. 1749	9	.145	
<b>(3)</b>	0040 F	RMI -AI -AC	1.00	ALTEN HOLF TO SPINDLE ROD		0760	<i>,</i> 9	.087	
	0050 E	KMM-BA-I C	1.00	RORE HOLE A X 1 1/2 BROLE 1	USE PROPER ELEMENT/TABLE	. 2641	, a	.303	
				REM RPL PAPRWRK SIGN OFF DO		.0100			
	0055 JA 01	_			BEARING BORE REP - JIG BORE				2
					RPRORATE OVER 4 PARTS			.230	-
	002C E			HOIST HANDLE NO WRAP 2 CLAM		.1577		.181	
<b></b>	0030 E			ALIGN VERTICAL AXIS ROD	u	.1269		.145	
	0040 E			ALIGN HOLE TO SPINDLE ROD		.0760		.087	
	0050 E				USE PROPER ELEMENT/TABLE			.303	
()	0050 E			REM RPL PAPRWRK SIGN OFF DO		.0100		.011	
	0057 JA 01		1.00	THE THE PERSON STOP OF THE	BEARING BORE SEAT REP.MED		.116		41
	0010 E			SZULVERT MILL BORE LAG ETYT	R PRORATE OVER 4 PARTS			.230	74
٦	0020 E			HOIST HANDLE NO WRAP 2 CLAM		.1577		.181	
				ALIGN VERTICAL AXIS ROD	* 010 DOIL	.1269		.146	
	0040 E			ALIGN HOLE TO SPINDLE ROD		.0760		.027	
	0050 E				USE PROPER ELEMENT/TASLE			.232	
	0060 E			REM RPL PAPRWRK SIGN OFF DE		.0100		.011	
	00 <b>59</b> JA 01		.07	ALL TO E THE THIRD CLOSE OF DE	O/S HOLE ON MILL/LARGE PART	994	.009		3
25	0010 E			S/II UERT MIL BORE EYTE HOTS	STPRORATE OVER 4 PARTS	1 0345		.298	~
	0020 E			HDIST HANDLE NO WRAP 2 CLAN		.1577		.181	
	0030 E			ALISH VERTICAL AXIS ROD	ai	.1269		.146	
**	0040 E			ALIGN HOLE TO SPINDLE ROD		.0760		.097	
	0050 E				USE PROPER ELEMENT/TABLE	.2641		.303	
	0040 E								
	0080 E 0073 JA 01		.07	REM RPL PAPRWRK SIGN OFF DO	il Inst Bearing Bore Bush & Cup	.0100	.001	.011	٨.
					PRORATE OVER 4 PARTS			.005	(·
	0010 E 0026 E			INSTALL ONE STRAIGHT BUSHIN		.1865		.053	
. 1	VV20 E	NEW-EG-H4	1.00	וואסנאבב נותטואחום באוט באון כאון	KC .	.0206	5 <u>4</u>	.023	

<u></u>	. 0070 T	nan na na	1.00 SEM 55 FEARN SIBN SEF DCC	A4.AA4	• • •	
•	19960 E 3374	nunnewna.	AF	.01001		
	0010 E	1. A. D., 67	.05 MACH BEARING ENIRABE HOAM .05 SET UF SMALL MUIDEM LATHE BEARING TO THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTOR OF THE BEARING FACTO	.205 - 2002 40015	.::4	:
1814	9010 E 8050 E	71975UF51	.14 SEP OF SAMEE MEDIUM LAPRE FROM 2 DVEN * THATS	44751	.147	
	Willy I	RUMTERFUL	1.00 IST PART IN-OUT SCROLL CHUCK 1.00 BIA 5.00-6.00 REM .000050 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01005	.011	
_	0000 5	575 50 51	1.00 PIR GARDENO DEL ARCET.IDU 4.00 PEM DOU DADOURY DEPA DET DOC	.0717.	:0E	
	9043 5		1.00 RED BALL PHERWAR SIGN OFF DUC	.01001	.011	
	0075 JA 01					0
	0010 E	KBW-BU-bl	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS			
়ী	0020 =	44-טפראפה אם נופ פנס	1.00 INSTALL DNE STRAIGHT BUSHING 1.00 REM RPL PAPRWRK SIGN OFF DOC	.02062	.023	
•	0030 E	KUF-FW-KI	1.00 REM REL PARAWAY BIDA UTF 1993		.011	
	0077 JA 01	15	.10 INST BEARING BORE BUSH & CUP			0
<b>3</b>	0010 E	KBW-81-81	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
	0020 E	KBW-BU-44	1.00 INSTALL DNE STRAIGHT EUSHINS	.02062	.023	
			1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.0::	
3	0079 JA 01					1
<u>آي</u>	0010 E	rla-su-s3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		
	0020 E	rla-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK	.01005	.011	
)	0030 E	KML-TA-JC	1.00 DIA 5.00-6.00 REM .033250	.09193	.105	
9	0040 E	RJP-PW-R1	1.00 1ST PART IN-DUT SCROLL CHUCK 1.00 DIA 5.00-6.00 REM .033250 1.00 REM RPL PAPRWRK SIGN OFF DOC .07 INST BEARING BORE BUSH & CUP	.01001	.011	
	0079 JA 01	15	.07 INST BEARING BORE BUSH & CUP	.077 .001	.006	0
<b>)</b>	0010 #	7 HW-HI1	25 Set OF ALBERTH MISSES PRIMATE INFR 4 PARTS	18669	.053	
ુંત	0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING	.02062	.023	
	0030 E	rjp-pw-r1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
	0080 JA 01	15	1.00 INSTALL ONE STRAIGHT BUSHING 1.00 REM RPL PAPRWRK SIGN OFF DOC 1.00 INSTALL HELICOILS 1.00 SET UP TO INSTALL HELICOILS 4.00 INSTALL HELICOIL INSERT 1.00 REM RPL PAPRWRK SIGN OFF DOC	.431 .065	.496	23
8	0010 E	RBW-SU-H1	1.00 SET UP TO INSTALL HELICOILS	.31093	.357	
	0020 E	RBW-TR-H1	4.00 INSTALL HELICOIL INSERT	.02763	.127	
<b>Æ</b> :	0030 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
<u>ۇ</u>	7000 06 00	13	LHEUR DIHNDHUR MISIUMI	.000 .000	.000	0
	0010		09 APRIL 87-REBUILT STD TO MATCH INNER WHEEL HALF-			-
<u>ب</u> ــــ.	0011		REMOVED OUTER TIME TO OPERATION MOOSO-OLD STD 2.78			
<u> </u>	0012		22APRILB7-REBUILT SUP02 0044 TO MATCH 958 0.S 1.69			
	0900		OF APRIL 87-REBUILT STD TO MATCH INNER WHEEL HALF- REMOVED OUTER, TIME TO OPERATION MOOSO-OLD STD 2.78 22APRIL87-REBUILT SUBOP 0044 TO MATCH 958 O.S 1.69 DOUGLAS JENSEN MANEL 73357			
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		4886 _5		ಗಳು ಸಂಪರ್ಣ ಗಳು ಪ್ರದರ್ಭವಾಗಿ ಪ್ರಕರ್ಣ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಣ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರ ಪ್ರವರ್ಥ ಪ್ರಕರ್ಣ ಪ್ರವರ್ಥ ಪ್ರಕರ್ಣ ಪ್ರಕರ್ಣ ಪ್ರಕರ್ಣ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ ಪ್ರವರ್ಥ	) MNPRA 481-4-497			7199	45 mag 1 25 m
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4,34.7	0010	. =	ن م <del>ح</del>	00-07311 100/	MACH WHEEL HALF OUTER C-5B FART NUMBER/NSN 0011084043 THREAD INSERT REPAIR	975	400	0.40	3
	0040 69 01	10	.00	AL DOD DENOU LIGHT DENEDA	INDERV INSERT REPRIN	.000 0751	.000	.316	4
	0010 E	######################################	1.00 5	/U FUR BENUM WURK DEMERAL	RT4 SCREWS-4 HOLES	. 27 da	.u 79		
`••`	0020 E	Kawrin-al	5.00 1	WILL THE & INDIALL DUTTES	114 SUREWST4 NULES	.000/	(7 54	.632	
	0030 E	KJE-FW-KI	1.00 R	EM RPL PAPRWAR SION USS US	N DRILL 2 HOLES	.0100	/1	.011	
(3)	0043 JA 01	15	.05		REMUVE BRUKEN SUREWS	. აამ	.005	.019	1
6.54	0010 E	RBW-SU-61	1.00 5	/U FOR BENCH WURK GENERAL		.2/52	Ω ···	.316	
	0020 E	RSB-JP-03	1.00 P	REP HAND DRILL FOR USE		.0088	51	.009	
()	0030 E	GAE-TL-02	2.00 D	RILL W/HND DRILL TO 1/4 II	N DRILL 2 HOLES	.008	/1	.020	
69	(H)C(I) ←	.!! K-W5-UK	7.141		SERV / SUBSEMS CROTHUL!	. U1Z.	32	.020	
	0050 E	GCL-CA-A4	2.00 0	LEAN BLIND HOLE WITH AIR	2 HOLES	.0012		.002	
<b>a</b>	0060 E	rjp <del>-pw-</del> ri	1.00 R	EM RPL PAPRWRK SIGN OFF D	DC	.0100	01		
<b></b>	0045 JA 01	15	.93		OC SAFETY VLVE HOLE REP S/U BORE FXTR(RML-SU-V2)	.983	.137		58
	0010 N		.50	•	S/U BORE FXTR(RML-SU-V2)	.9840	00	.565	
æ£)	0020 E	RML-HP-H1	1.00 P	ART ON/OFF MACH HAND NO R	A.P·	.030	58	.035	
3	0030 E	RML-AL-AA	1.00 A	LIGN HORIZ AXIS ROD		.0626	65	.072	
	0040 E	RML-AL-AB	1.00 A	LIEN VERTICAL AXIS ROD		.126	99	.146	
~	0050 E	RML-AL-AC	1.00 A	LISN HOLE TO SPINDLE ROD		.076	09	.087	
	0060 E	RML-BA-AB	1.00 B	ORE HOLE 1 X 1 GROUP 1		.1949	22	.212	
	0070 E	RJF-PW-R1	1.00 R	EM RPL PAPRWRK SIGN OFF D	OC	.010	01	.011	
	0048 JA 01	15	.09		S/U BORE FXTR(RML-SU-V2) AP  OC  VALVE STEM HOLE REPAIR L  OC  BEARING BORE REP.PENSOTTI  SET UP PENSOTTI  MACHINE BEARING BORE	.642	.007	.065	4
3	0010 E	R0R-SU-R1	1.00 9	S/U TO D/S BOSSES RAD DRIL	<u>L</u>	.563	78	.648	
	0020 E	KM: -D8-KB	1.00 D	NRILL HOLF 1/2 DIA 1 DEEP	_	.068	57	.078	
	0070 E	5,15-56-51	1.00.5	EM RPL PAPRWRK SIGN OFF D	ac.	.0100	01	.011	
(3)	0055 JA 01	15	05		REARING RORE REPLEENSATTI	.508	.004	.029	2
•	0010 N		1 00		SET UP PENSATTI	. 1670	00	.192	_
	0020 E		1.00	4 .26	MACHINE BEARING BORE OC/	. 293	22	.337	
	0020 5	0.10_084.01	1.00	EM RPL PAPRWRK SIGN OFF D	GP/	.010	01	.011	
	0040 E	DD: _MLi_S1	1.00 5	ET PALLET JACK & MOVE PAR	TS/	.038	15	.043	
	0058 JA 01		05	LI INCLI UNCK & HOTE INK	BEARING BORE SEAT REP, MED	797	.006	.045	3
<b>3</b>					TR PRORATE OVER 4 PARTS			.230	Ū
					MP JIG BORE		76	.181	
				ALIEN VERTICAL AXIS ROD	AL OIG DUNE		, o 99	.146	
3						.076		.087	
				ALIGN HOLE TO SPINDLE ROD				.248	
					USE PROPER ELEMENT/TABLE				
٧	0060 E			REM RPL PAPRWRK SIGN OFF D		.010		.011	C
W	0072 JA 01				INST STRAIGHT BUSH NO POLISH		.001		
					PRORATE OVER 4 PARTS	.186		.053	
0				INSTALL ONE STRAIGHT BUSHI		.020		.023	
اب				REM RPL PAPRWRK SIGN OFF D		.010		.011	
	0074 JA 01		.05		MACH BEARING BORE BUSHING		.002		
	0010 E				PRORATE OVER 4 PARTS	.499		.143	
				IST PART IN-OUT SCROLL CHU		.010		.011	
	0020 E	KML-TA-JC	1.00 I	01A 5.00-6.00 REM .03325	0	.091		.105	
,= <u>+</u> .	0040 E	rjp <del>-PW-R</del> 1	1.00 F	REM RAL PAPRWRK SIGN OFF D			01	.011	
٣	0076 JA 01	15	.05		INST BEARING BORE BUSH & CUP	.077	.001	.004	0
	0010 E	RBW-BU-61	.25		PRORATE OVER 4 PARTS	.186	69	.053	
				INSTALL ONE STRAIGHT BUSHI		.020	62	.023	
				REM RPL PAPRWAK SIGN DEF D			01	.0:1	
	0677 JA 01		.10		INST STRAIGHT BUSH NO POLISH		.601		
	0010 E			SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	184	. <b>6</b> 9	.053	
1	AA1A F	11247 20 01		Jan de la mande la nadada	THE STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF STATE OF				

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. 1	0010 E	REW-EU-44 ::	s _{kit} kirika aka araasan susan	:	.02052	.027	
	WII E	£3=+5%+ <del>8</del> ;	1.00 REM REL PAPRARY SIGN OFF DO	2	.01001	.0::	
-	007 <b>5</b> JA 01	15	.05	MACH BEARING BORE BUSHING	.002	.014	:
• •	0010 E	RLA-90-93	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.47962	.147	
	G200	RLA-HF-01	1.00 IST FART IN-OUT SERELL CHUC	X	.01005	.011	
	00 <b>30</b> E	HML-TA-JC	1.00 DIA 5.00-6.00 REM .033250	)	.09193	.105	
	0040 E	rje-fw-r1	1.00 REM RPL PAPRWAK SIGN OFF DO	90	.01001	.011	
	0079 JA 01	15	.05	INST BEARING BORE BUSH & CUP	.077 .001	.004	0
A75	0010 E	RBW-BU-91	.25 SET UP TO RESUSH BOSSES	PRORATE OVER 4 PARTS	.12669	.053	
	0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHIM	₹8	.02042	.023	
	0030 E	RJF-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DO	20	.01001	.011	
200	0030 JA 01	15	1.00	INSTALL HELICOILS	.431 .055	.496	27
<b>a</b>	0010 E	RBW-SU-H1	1.00 SET UP TO INSTALL HELICOILS	5	.31093	.357	
	0020 E	RBW-TR-H1	4.00 INSTALL HELICGIL INSERT		.02763	.127	
-	0030 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DO	OC	.01001	.011	
0	9000 JA 01	15	.01	LABOR STD HISTORY	.000 .000	.000	0
	0010		21MAY85 DWN GRD TO N STD (1	FM WAS 2.40)			
.42% <u>.</u>	0020		09 APRIL 87 RM SUBOPS 0044-	-0110 NLD OLD STD 2.			
٧	0900		D. FARKER TECHN MANEAA				

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	CPER TECH S S W F FF A/R REV SUB T X #R A FA SUFFERT STEP D L N C DO ELEMENT		BASE FFD HOURS TIME	STD 4 HOURS DLY POT D
<b>1</b>	RC103 S E UP EA B	1.00 PERCENT ENSR 99.9 PLT. C5BM WHEEL HALF, INNER 1.00 PART NUMBER/NSN 300-329-1 1630011094044	.94 .000 .000	<b>.94</b> .000 0
	0050 UP 01 24	1.00 SHOT PEEN MED PART/MASK 1.00 MASK UNMASK EXT PLATE AREA 1.00 SHOT PEEN SMALL/MED PART	.301 .072 .12999 .16131 .01001	.374 40 .161 .200 .012
٥	0070 UP 01 24 0010 E RWB-CV-D1 0020 E ZPL-AN-M1 0030 E RJP-PW-R1	1.00 ANODIZE MED PART 1.00 VAPOR CL (DEGR) HOOK/BASKET 1.00 ANODIZE MEDIUM SIZE PART	.460 .111 .08709 .36341 .01001	.107
<i>ᢒ</i>	9000 UP 01 00 0500	.00 LABOR STANDARD HISTORY 8 APR. 1988 RICHARD 6. MARTIN MANEL-73357-MRPII	.000 .000	

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•	74958250101482104								
~		LABOR STANDARD -5 M WHL ABBY. F FF A/R RBV	EFERHIJON REBOURCE S	TANDARD AND METHOD ANALYSIS ROD MNFRO				-2Y-M45 7198	FASE COC1
	SUB TR #R					PASE HOURS	SFD TIME	57 <b>1</b> HDURS	1 11y FOT D
3	RC104 S E UF EA 0001 GF 01 0010	00 1.00		PLT CSB M WHEEL HALF FART NUMBER/NBN 1630011084043	OUTER	.94 .000	.000	.54 .000	0
Ģ	0050 UP 01 0010 E 0020 E 0030 E	24 1.00 RPL-M4-AA 1.00 RPL-SP-M1 1.00		SHOT PEEN MED PART/M TE AREA PART	ASK	.301 .1299 .1613	1	.374 .161 .200 .012	40
<b>3</b>	0070 UP 01 0010 E 0020 E	24 1.00 RWB-CV-D1 1.00 ZPL-AN-M1 1.00	VAPOR CL (DEGR)HOOK/ ANGDIZE MEDIUM SIZE	ANODIZE MED PART /BASKET PART		.460 .0870 .3634	.111 9 1	.571 .107 .450	.8 60
Ø	0030 E 9000 UP 01 0010	RJF <del>-PW-R</del> 1 1.00 24 .00	3JUNE86 REWROTE STD	LABOR STANDARD HISTO TO MATCH 958 WORK PREVIOUSLY			.000	.012	0
0	0011 0900		DONE ON OPERATION XI KERRY COOP M	NPRC (OLD STD .425) ANEL TECHN 73357					·

RCC PRD NROP NR

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	7MN=6490101443601			
<b></b> .	POIDEA S A SEER TECH B.S. A	LABOR STANDARD GFERA:11 H5 M WHL 488Y. F 99 4/R 8EV	IN REEIURGE STANDARD AND METHID ANALYBIS ROJ MNAGA	11/14/EE 4-E046E-MM1-D7-M4E F4EE 0//11 4W1-4-4F0 E71FE
3	SUB 7 K #R STEP D L K	A FA SUFFDAT   DOD < C DO ELEMENT   FACT	SEBORIPTION	E4SE FRO STD 6 - HOURS TIME HOURS DLY POT D
<u></u>	W2001 B N KI EA 0001 KI 01 0010 0020	00 1.00 3-12 <b>69-</b> 3	ENGR 54.9 C5B MAIN WHEEL INNER PART NUMBER/NSN 3 1530011826267 -1170 1630011526267	R .59 .59 .000 .000 .000 )
3	0007 KI 01 0010 N 0020 E	27 1.00 ZLB-CL-M1 .50 LGAD & L	CHEM CLEAN WHEEL ALK UNLOAD CARRIER CLEAN PAPRWRK SIGN OFF DOC	JM .116 .031 .147 2.5 25 .21200 .134 .01001 .012
9	0009 KI 01 0010 E 0020 N 0030 E	ZLG-CL-Mi .50 LOAD & L	BLAST CLEAN WHEEL ME ST MED PART WALK-IN B UNLOAD CARRIER CLEAN PAPRWRK SIGN OFF DOC	ED .217 .059 .277 46 .10180 .129 .21200 .134
(3)	0011 KI 01 0010 E	27 1.00 ZCD-ST-S1 1.00	ANDDIZE STRIP WHEEL ANDDIZE STRIP	ALUM .136 .037 .173 .7 29 .12530 .160
9	0030 E 9000 KI 01 0010 0900	27 .01 18JUL85	PAPRWRK SIGN OFF DOC LABOR STD HISTORY MOVED N&B TO HB SKL (TM WAS .66) R TECHN MANEAA	.01001 .012 .000 .000 .000 G

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		LABOR BTANDARD G-5 % who ASBY. IS SE BYR REV	ERERH, LON RESOLACE STANDARD ROO	AMPEN MMPEN	11/14/99 4W1-4-4FT	4-594	112- <b>m</b> m: 8	-14- <b>*</b> 45 7198	F43 <b>E</b> 0000
	S13 7 48			::::::::::::::::::::::::::::::::::::::		3345	555	575	<u>-</u>
	STEP D L K	O DO ELEMENT FAUT	STORED	SUFPLEMENTAL		H3URS		43048	DLY POT D
	MD001 8 E HE EA			DISSY WHEEL COA M	211E	.97		.?7	
<i>5</i> 3.	0001 HB 01			PART NUMBER/NON		.000	.000	.000	Ç
	0010		4894000-1170 16300						
		25 1.00					. 152	.758	78
	0010 E	RWS-39-W1 1.00	PREP TO DISASSEMBLE WHEEL			.0163	-	.020	
·5 '	9020 E	AWE-HEB 1.00	PREP TO DISASSEMBLE WHEEL   HNDL E/I PRTS (ALL WHEELS)EA   HANDLING TOOLS PER END ITEM	İ		.0228		.029	
						.1383		.172	
(2)			REM UNOBSTR WHL TIE BOLT	_		.01056		.237	
* April			REM BRAKE KEY (ONE RET SCW)				1		
			REM DATA PLATE & STAMP WHL			.0306		.076	
(;)	0070 E		REM BEARING (SNAP RING SEC)			.01221		.030	
27.	0080 E		DIS WHL (V/L-L & M WHEELS)	• · · •		.0426		.053	
	0090 E		REM HEAT SHIELD (SINGLE PC)			.0021		.002	
<b>(2)</b>	0100 E		REM REL FAPRWRK SIGN OFF DOC			.0100		.012	•
	0006 HB 01	25 1.00		KENUVE BEAKING LUP			.043		22
			REMOVE BEARING CUP LOAD HOOK W/WHEELS F/CLENING			.0281		.070	
			REM RPL PAPRWRK SIGN OFF DDC			.1053		.131	
Q,	9000 HB 01		KEN KEL PHEKWAK SION DEF YOL			.0100		.012	^
	0010		10JUN85 CHANGED SKL CODE NO			.000	.000	.000	0
€	0020		OLD STANDARD .91	וה נתאט					
•	0900		26 SEPT 1988 MRPII RICHARD S	MADITAL MANEL TITET					
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	TYNESW90101AWE103			e ^{rr}				
€.		LABOR STANDARD HE Y WHL ASSY. F RF AVE REV		MARD AND METHOD ANALYSIS 11/24/9 ROD MARGW 481-4-49			-IY-M48 7198	94 <b>55</b> ((())
	SUB Tik #R	A FA BUFFORT COC C DO ELEMENT FACT	:	EBORIFTION	EAEE HOURS	EFI TIME	STD HOURS	2_V FCT 2
<b>⊕</b>	WE107 E N DI EA 0001 51 01 0010	60 1.00		CSE MAIN WHEEL INNER PART NUMBER/NEN .630011084044	.5: .000	.000	.51 .000	÷
<u></u>	0019 DI 01 0010 E 0020 N	RLB-RB-AJ 1.00 1.00	NICK & BURR FT8-CONST F/	NICK & BURR WHEEL MED/HALF FREP NICK & BURR WHEEL MED/HALF	.250 .02311 .21681		.019 .029 .275	±1
(2)	0030 DI 01 0010 N	15 1.00 1.00		E & I AND ROUTE WHEEL E&I AND ROUTE WHEEL HALF	.14919	.025	.012 .193 .171	28
<b>@</b>	0020 E 0030 E 9000 DI 01			DOC LABOR STANDARD HISTORY	.00833 .01003 .000		.009 .011 .000	0
<b>(</b> )	0010 0 <del>9</del> 00		26FEBBS NEW REQUIREMENT/ N MONROE MANEAA 73.57	ini, inc input				

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	CRER TEIN B B 14 :	-5 M NHL 488%. F FF 1/8 81V		ROD MNR6W 4	11):4/33 W1-4-497		_	-09-445 7195	7 <b>921</b> - 1911
."		A FA BUFFORT DOC . D DD BLEMENT FAST	STORED	TEORIFTICASUPFLEMENTAL		HOUFS	TIME	STI HOURE	DLV FDT D
	WE104 E N DI EAS		ERCENT ENSR 12.3	CSS MAIN WHEEL DUTER		.51			
7	0001 DI 01 0010	- 00 1.07 - 3	00 728-1 :	FART NUMBER/NEN 630011084.43		.000	.000	.000	Ģ
্য	0010 E		ICK & BURR PTS-CONST F/	· · <del>-</del>		.250 .02312		.313	έŹ
1,17	0010 N 0030 E	:.00 RJP-PW-R1 1.00 R	EM RPL PAPRWAK SIGN OFF	NICK & BURR WHEEL MED/ Dec	HALF	.21537 .01001		.275 .012	
9	0010 N 0100	15 1.00 1.00		E & I AND ROUTE WHEEL AND ROUTE WHEEL HA		.167 .14919		.193 .171	33
<b>(3</b> )	0020 E 0030 E	RJP-PW-R1 1.00 R	EMV WHL HLF F/PAINT CON EM RPL PAPRWEK SIGN OFF	DOC		.00833		.009 .011	
وسيا	9000 DI 01 0900	00 .00	B APR. 1988 RICHARD 6.	LABOR STANDRD HISTORY MARTIN MANEL-73357-MRPII		.000	.000	.000	0

RCC PRO NROP NR

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90101A	LABOR STANDARD C-5 M WHL ASSY.	OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/01/ RCC MNPNA 4P1-4-4		L-DY-M45 FAGE 0001 37198
SILE I.Y.	W F PF A/R REV R A FA SUPPORT OCC K C DC ELEMENT FACT	<> STORED DESCRIPTION> STORED SUPPLEMENTAL		STIO A HOURS DLY PCT C
ONENA S X DB E 0015 DB 0 0010 E	1 11 .13	FERCENT ENGR 99.9  CSB MAIN WHEEL INNER  NNI TIE BOLTS 1ST TIME  MAGNAGLO INSP SMALL OBJECT	.31 1.005 .014 .09138	•31 •145 46 1•115
0020 DB 0 0010 E		NDI DRIVE KEYS 1ST TIME MAGNAGLO INSP SHALL OBJECT	.822 .012 .09138	•119 37 •912
2000 I/B 0 0010 0020		PART NUMBER/NSN 3-1268-3 1630011826267 4694000-117C 1630011826267	.000 .000	.000 <b>o</b>
2001 DB 0 0010 E 0020 E	ZLG-ND-Z2	ZYGLO WHEEL MED LYGLO INSP MED PART BLD 507 REH RPL PAPRWRK SIGN OFF DOC	.273 .030 .13177 .01001	.304 .7 96 .292 .011
9000 DB 0 0900	1 00 .00	LABOR STANDARD HISTORY 21 MAR. 1988 MRPII-RICHARD G. MA.TIN-MANEL-73357	.000 .000	.000 0

RCC PRD NROP NR <--->

A L

STL-STEEL
AL-ALUNINA
NG-WABESTUM
TITIP-IITANIUM
SS-S STL
SYNESWINETIC
LD-EAD

F-4 NOSE WHEEL

BILL OF MATERIALS

162678

	TOWN LEVELS:	E. PART	STOCK	. VENDOR :	: NOMENCLATURE	UNITSIU	NIT:YIEL	UNITSIUNITIYIELDISCRAP :PART :MIC ; REV :I	PART THIC	EV 3	EFFECTIVITY CONTROL	UNITSIUNITIYIELDISCRAP IPART INIC ; REV SEFECTIVITYITECH (RO : PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PEDGING ; PED	PENDING:	PERMINE	PENDING
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	Ξ:	:220A282	11630011611591	SZZZ	I. HEEL HALF ASSENDLY (INBOAND)	<u>₩</u>	- «					·	• •-		
턽	12	11305610	13110002770372	B£009:	ICUP, BEARING	11 AR (54	~ •								
æ	12	12204284	: 5X30009360620LE		I BAFFLE, OPEASE RETAINER	:: 25	 •					••			
띪	:2	:2194189-1	11630009153183	:73808	: WEIGHT, BALANCE . 2502	:: AS:EA	 «								
F)	12	:2194169-2	11630009153184	173808	: HEIGHT, BALANCE . 50 oz	.: AS:ES	 e			14					
ST.	2	1219A189-3	11630009153185		SHT. BALANCE	23:54 13:	 •			æ	-				
ST,	2	12194189-4	1630009173110	73808	BALANCE	53.54	·	·		1	~ <del>-</del>				
	2	:AM520-10R14	5305007716012	11088	EN. NEIGHT	\$3.58 1.58	 : <			·					
	12	: AN960-10L	15310001670834	14088	. MOSER, WEIGHT	.: Æ:E			·		- <b>-</b>				
		1MS20364-1032C	15310002752025		INUT, WEIGHT	T ARIEA	- «			-				·	
STL/STA		2204286	:SXX0009360623LE	173808	:SEAL, BREASE (I.B.)		 E								
STL	12	1207A247	15365005346651	173808	:RING RETAINING (1.B.)	:: 25	 •								
	12	in.P.L.	N.S.L.		MEEL HALF SUBASSY (INBOARD)	==									
	3	:N.P.L.	.N.S.L.		1SLEEVE & CUP ASSY (PSEUDO)	æ ₩	••								
	****	12204401	:3120004887091LE	173808	:SLEEVE, BEARING CUP	<u>=</u>	 «								
	****	1,305610	13110002770372	820091	ICIP, BEARING	:: 25	 «					••			
		1220A282	IN.S.L.	123233	IMEEL HALF (INBOARD)	==									
	-:	12204283	91023311002911	12223	I. WEEL HALF ASSENDLY (QUIBONO)	==	 •								
鬞	2	1,102810	:2110001861114		BEARING	11 AR:EA	 •								
鬞	2	12194189-1	11630009153183		HI, BLAKE	11 AR ES	 ≪								
Ę.	:2	:2194189-2	11630009153184		HI, BALANCE	.: <b>3</b>	 •			 		••			
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E E	2	12194189-4	11630009173110	7,808	NEIGHT, BALANCE 102	 85 85 85 85 85 85 85 85 85 85 85 85 85				<u></u>					
		14620-10814	5305007716012	1088	SOREN, MEIGHT	43.54 1.15 1.15 1.15 1.15 1.15 1.15 1.15 1		•			•	•			
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<b>.</b>	7	1220A285	3330007360621LE	9082	BAFFE F. GREACE RETAINER		 {		• •-		- ••				
is:	12	2064247	:5365009340568		RING, RETAINING (0.B.)		 «		. <b></b>	·				- <b></b>	
STL/SMI		12204287	:5330009360624LE	173808	SEAL, GPEASE (0.B.)	== ==									
		IN.P.L.	H.S.L.		WHEEL HALF SUBASSY (OUTBOARD)	==									
	5	K.P.L.	N.S.L.		SLEEVE & CUP ASSY (PSEUDO)	₩ ::									
	<b>*</b> ····	:2204403	:3120002251936LE	73808	:SLEEVE (DEARING CUP)	## ##	 «				••	••			
	¥	:L102810	:3110001861114	E00091	iCup, BEARING	<u>55</u>	 «		•						
	53	: 220A2B3	:N.S.L.	1222		==								•-	
鬞	12	:NS20002-5	:5310002000058	90696:	4	REPAIRED) : 10 AR: EA							•-		
	Ξ:	: TR752-03	:2640007267896		I.WILVE ASSEMBLY, CHARGING	2. 2.	 «								
	:2	.V.	11650002224525		:CAP,WALVE	:: ₩	 «	 			••				
	:2	<u></u>	:2640008105861	79934	:WLVE,CORE	 83	 «								
	:2	: R630	HX1787914000000000000000000000000000000000000	155471	:PACING,O-RING	<u></u>	 Œ								
E E	:2	:TR752	:N.S.L.	179934	:STEM, WALVE	==									
		:N.P.L.	.X.S.L.		:.WALVE & PACKING ASSY (PSEUDO)	æ ==				<u>4</u>				*-	
5	12	:MS27436-3	12640001166208	90696	:VALVE ASSEMBLY OVERSIZE	 	 «								
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F-4 NOSE WHEEL

BILL OF MATERIALS

STL-STEEL
AL-ALUFIAN
MG-MGRESIUM
TITA-TITANIUM
SS-S STL
SYN-SYNTHETIC
LD-EAD

162678

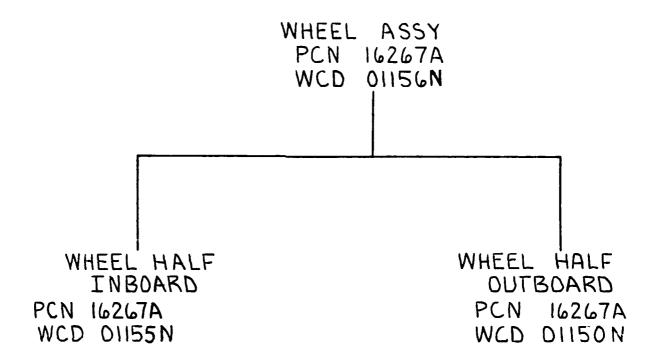
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: XX:	CODE:	 ü	<u> </u>    -		
1949	TOR! TYPE	a,	L	<del></del> -	
YIELDISC	PATE : FAC		<u> </u> 		
ITS:UNIT:	# 150 H	SY :NEAS:	<u> </u>	<u>25</u>	<u>s</u>
: NOMENCLATURE				:.PACKING,O-RING	:.PACKING O-RING
: VENDOR : NOMENCLATURE	: 0006 :			:23233 :. PACKING, D-RING	196906 1. PACKING D-RING
: VENDOR :	NUMBER : CODE :		<u> </u>		
: STOCK : VENDOR :	NUMBER		<u> </u>	:23233	90696:
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## THE WHITE LAND

					4.7			*
		CONTROL JOP NUMBER DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	6919 FLOW DAYS
JENS	<b>R168</b>	15 <b>585</b> A -J	F-186 MLG	Brake assy	163 <del>8-86</del> -165-1 <b>9</b> 29	1518 <b>66-2</b>	4B1-4-223	24
	RIG8	15587AG-J		BRAKE PRESSURE PLATE	163 <del>8-98</del> -264- <del>9</del> 752	329-16-1	481-2-483	19
JENS		15592A <b>√</b> -6-J		#EEL	16 <del>38-98-4</del> 21- <b>9</b> 319	211A243H3	46-上13	34
JENS	RIGB	156 <b>01A</b> -6-J		Brake assy.	163 <del>9-00-</del> 553-4734	9556338-1	4B1-2-1973	28
JENS	RI6B	15603A <b>√</b> -6-J		BRAKE BACKING PLATE	163 <del>8-88-59</del> 1 <del>-8349</del>	2601844	481-4-263	16
JENS		'15616A ¬J	C-141 MLG	BRAKE BACKING PLATE	163 <del>0-99-</del> 567 <del>-8</del> 162	9533668	491-2-373	19
jens	R168		F-186 MLG	Brake Pressure Plate	163 <del>8-89-6</del> 71-2838	151864	4B1-4-223	16
JENS	RIGB	15639A -G-J		Brake pressure plate	163 <del>0-0</del> 1- <del>005-</del> 4188	5002564	4B1-2-1 <b>99</b> 3	16
JE <b>NS</b>		15641A√-J	F-4 MLG	Brake Housing Sub Assy	163 <del>8-88-</del> 276-9849	5661896	<b>4B</b> 1-2-1 <i>0</i> 93	23
<b>JENS</b>	R16B	15642A <del>-6</del> -J		BRAKE BACKING PLATE	163 <del>0-0</del> 1- <del>00</del> 5-4189	5666263	4B1-2-1 <b>66</b> 3	19
DELE		15643A -6-J		WEEL.	163 <del>0-99-</del> 123-88 <b>9</b> 3	17 OCT 88	<b>4</b> W1 <del>-0-</del> 73	22
		156 <b>44A ~J</b>		Brake Housing	163 <del>0-00-</del> 123- <del>836</del> 4	5692269	491-2-1123	16
COOP		15651A -J	F-15 NLG	WHEEL.	163 <del>0-00-</del> 558-2584	<del>5000</del> 76 <del>0-</del> 2	<b>4M3-8-23</b>	29
JENS		15652A -G-J		WEEL	163 <del>0-0</del> 1- <del>00</del> 5-4262	5 <i>00</i> 0864	4W1-8-73	29
jens	COOP	15677A	A-7 MLG	STRUT ASSY	1629-61-174-1655	<b>8</b> 121 <b>0</b> 17 <b>-30</b>	4S1- <del>98-</del> 3	36
JENS		15678A	A-7 NLG	STRUT ASSY	1629-81-174-31782	8121917-1 <b>9</b>	451 <del>-98-3</del> 2	<b>1</b> 2
JENS	PRIC	15686A -G-J	A-10 NLG	WHEEL	163 <del>8-88-576-</del> 9637	3-1358	4143-4-433 •	16
jens	RIGB	15698A -G-J	C-5A MLG	Brake assy	163 <del>0-0</del> 1- <del>0</del> 41-4570	2-1179-4	481-2-1863	26
JENS	RIGB	15728A -J	C-136 ML6	Brake Holising	163 <del>8-88</del> -937-6684	9543 <u>433</u> . · ; ·	481=2-1663	16
JENS.	R168	15744A -J	F-15 MG A/B	BRAKE ASSY	1639-01-059-5274	5 <b>600</b> 913-12	4B1-2-1123	13
JENS	RIGB	15746A -J	C-141 NLG	WEEL	163 <del>0-0</del> 1- <del>08</del> 1-6687	3-1095	443-7-1943	29
	16B	15747A -J	F-15 ML6	Brake Backing Plate	1639-00-132-2021	<b>566</b> 2483	481-2-4123	16
	.6B	15749A -J	F-5 MLG	Brake assy	163 <del>8-68-</del> 227-2 <del>666</del>	M318196	487-2-453	20
JEN5	RIGB	15752A∕ <del>-6</del> -J	A-10 MLG	Brake assy	163 <b>8-8</b> 1-862-7846	5602372-5	481-2-1143	27
JENS	PRIC	15753A -J	E-3A MLG	WHEEL	162 <del>8-8</del> 1 <del>-607-84</del> 74	<b>9560</b> 5718	461-7-1353	29
JENS.	PRIC	15757A√ <del>-6-</del> J	C-130 NLG	WHEEL	163 <del>8-88-</del> 914-1329	219A967	443-4-363	23
MART	SHEL	158#3A -6	A-7.55	HOUSING TRANSFER UNIT	1 <del>005-00-239-2929</del>	175F631	1141-7-1-193	25
MART	SHEL.	15819A	•	BREECH MAU-12	1 <del>975-98-</del> 911-9497	64H13212-3	11829-3-25-2	12
JENS	PRIC	15822A -J	F-5 MLG	WEEL	1639-91-955-5956	259-A-168-C	41-1-43;	25
JENS	PRIC	15828A√J	F-16 MLG	WEEL 4-	163 <del>8-8</del> 1-838-9239	5663662	441-7-1363	25
JENS		15834A	F-16 MLG	PIN ASSY	1629-91-971-9536	<b>2964664</b> -1 <b>9</b> 3	4S1-1 <del>09-</del> 3	E
MART		15849A	MUTIPLE	AIR FOIL MXU02A/B	1325-66-142-6244	487899-2- T	#K1-9-3	25
		15862A	F-16 NLG	PISTON ASSY	1629-61-671-6538	2006602-103	452 <del>-80-</del> 3	35
		15865A	C-141 ML6	FORWARD LINK	1629-98-927-2661	3616613-111	451-73-3	21.
COOP		15866A	C-11+ M.G.	STOLET; AGSY H/W	1426-61-163-7747	TJ 29965-16	61-87-23	22
DELE		15874A -6-J		BRAKE HOUSING	1636-91-124-2873	19 OCT 88	481-2-1923	28
	COOP	15984A	F-111 ML6	PIN SHOCK STRUT	162 <del>9-93-480-</del> 19 <del>9</del> 7	121,9519-5	444-15-3	30
JENS		15998A	C-136 NLG	STRUT ASSY	1629-01-146-5708	7926623-19	452-23-3	65
		16019A √-J	F-4 NLG	STRUT ASSY	1626-61-624-8844	<b>53-454<del>00</del>-30</b> 1	452-57-3	69
MART		16039A	F-16	ECH ADAPTER	1568-81-142-6594WF		1646-35-3-2	15
MART		16 <b>679A</b>	MULTIPLE_	LAU-186 LANCHE R/H AIM 9		7839472-60	11L1-3-11.	Zi
PARK		16 <b>181A</b>	LEM-34	TAEL ACTUATOR	145 <del>8 86 807 8</del> 746AH		3503-11-25-13	
JENS		16123A <b>~</b> -6-J	<b>A</b> -	<u>.</u>	162 <del>9-98-</del> 677-6681	1656E412	1663-2-48-23	25
JENS		16136A	E-3A MLG	BRAKE TORQUE TUBE	1638-81-834-5387	9542482	4B1-2-1153	13
MART		16148A	F-4	CENTERLINE ADAPTER ASSY			1F4C-3-1-4	tale:
MART		16228A	MULTIPLE		1325-66-471-9664	689898-1	11K1 <del>-9-3.</del>	售
MADT	_	16229A	MULTIPLE		1325-69-491-8667	780924-1	11K1-9-3	16
	, ,	16264A	KC-135 MLG		162 <del>8-88-</del> 67 <b>8-6682</b>	69-1172-1	444-12-23	45
		16266AV -6-J		WEEL	163 <del>8-89-</del> 73 <del>8-9</del> 126	3-1185	443-7-1163	19
JEME		16267A - 6-J			WW-49-652-1872		40-7-185	**
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## F-4 NOSE WHEEL



## F-4 NOSE WHEEL PROCESS FLOW

PCN 16267A

WCD O1156N WHEEL ASSY

IN INDUCT

WCD OII55N INBOARD HALF

5 SPLIT WHEEL

WCD OII50N OUTBOARD HAL

5A DISASSEMBLE KEYS, CHILLS, WEIGHTS, ETC. SA DISASSEMBLE KEYS, CHILLS, WEIGHTS, ETC.

- 6 HEAT TO 150°F-REMOVE BEARING CUP & STAMP WCD
- 6 HEAT TO 150°F-REMOVE BEARING CUP STAMP WCD
- 7 LOAD ON OVERHEAD CONVEYER
- 7 LOAD ON OVERHEAD CONVEYER
- 7A CHEMICAL CLEAN
- 74 CHEMICAL CLEAN
- 78 UNLOAD FROM OVERHEAD CONVEYER
- 78 UNLOAD FROM OVERHEAD CONVEYER

9 BLAST CLEAN

9 BLAST CLEAN

10 REMOVE BEARING BORE BUSHING

- 10 REMOVE BEARING
  BORE BUSHING
- 11 BLAST CLEAN BORE
- 11 BLAST CLEAN BORE
- 12 LOAD ON OVERHEAD CONVEYER
- 12 LOAD ON OVERHEAD
  CONVEYER

12A STRIP ANODIZE

IZA STRIP ANODIZE

- 15 PENETRANT INSPECT
- 17 UNLOAD FROM OVERHEAD CONVEYER
- 19 NICK & BURR GRIND
- 30 EVALUATE & INSPECT-DELTA STAMP WCD AS REQUIRED
- 45 BEARING BORE REPAIR
- so TIE BOLT FACE REPAIR
- 65 MOVE TO BLOG#505
- 70-70K SULFURIC ANODIZE
  - 72 MOVE TO BLOG \$507
  - 75 INSTALL BEARING CUP
  - 80 MACHINE BUSHING & CUP
  - 85 INSTALL BAFFLE, CUP, BUSHING
  - 90 VISUAL INSPECT &
  - 95 HEAT TO 230° F
  - 95A UNLOAD OVEN F INSTALL BEARING RACE

- 15 PENETRANT INSPECT
- 17 UNLOAD FROM OVERHEAD CONVEYER
- 19 NICK & BURR GRIND
- 30 EVALUATE & INSPECT

  DELTA STAMP WCD

  AS REQUIRED
- 45 BEARING BORE REPAIR
- 50 TIE BOLT FACE REPAIR
- 60 VALVE STEM HOLE REPAIR
- 65 MOVE TO BLOG # SOS
- 70-70K SULFURIC ANODIZE
  - 72 MOVE TO BLOG # 507
  - 75 INSTALL BEARING CUF
  - 80 MACHINE BUSHING & CUI
  - 85 INSTALL BAFFLE, CUI
  - 90 VISUAL INSPECT &
  - 95 HEAT To 230° F

100 LOAD ON OVERHEAD CONVEYER

100A WASH

1008 PRIMER SPRAY

1000 AIR DRY

1000 MASK

100E PAINT 1ST COAT

100F PAINT ZND COAT

100G AIR DRY

100H STRIP MASKING

100I UNLOAD FROM OVERHEAD CONVEYER

120 Install Seals &
RETAINERSBUY-OFF WCDFINAL VISUAL INSPECT

95A UNLOAD OVEN & INSTALL BEARING RACE

100 LOAD ON OVERHEAD CONVEYER

100A WASH

1008 PRIMER SPRAY

1000 AIR DRY

100 D MASK

IOOE PAINT 1ST COAT

100F PAINT ZND COAT

100G AIR DRY

100H STRIP MASKING

1001 UNLOAD FROM OVERHEAD CONVEYER

IZO INSTALL SEALS É
RETAINERS
BUY-OFF WCDFINAL VISUAL INSPECT

WCD DII56N WHEEL ASSY

10 MATCH- UP

IS ASSEMBLE WHEEL HALVES TOGETHER

20 TOUCH-UP PAINT

997 VERIFY WCD COMPLETENESS

998 FINAL VISUAL INSPECT

9999 SELL

			ROL DOCUMENT (ME		<u> </u>		PAGES -		
JOB ORDI		3. QUANTITY	4 PRODUCTION SE	CIRCG 5 DA	TE SCHED	6. DATE COM	PLETED		
			In Tech Data						
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4 D	006 *REGE*	REMOVE C	OUP FOOT W		P 60V.5		001 AN 002 02 003 WDd	9 W		
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# PSW18257AWD001

LASER STANDARD CRERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/02/88 A-E0468-MM1-DY-M45 FAGE 0001
REC MNPGW 4W3-7-1143 81279
LASER STANDARD CRERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/02/88 A-E0468-MM1-DY-M45 FAGE 0001
REC MNPGW 4W3-7-1143 81279

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	)	T K	#R	A FA SUPPOR	T 900	< DES	CRIPTIEN	<del></del> >	FASE	PFD	מדפ		А
-51	EP -	D L	K	OD SLEYEN	FACT	STORED	SUPPLEMENTAL		HOURS	TIME	HOURS	DLY P	CT E
701	S	E HB	EA :	5 <b>J</b> 8830	1.00	PERCENT ENGR 99.9	DISASSY F4 NOSE WHEEL		.48		. 48		
0001		39	91	00	.00		PART NUMBER/NSN		.000	.000	.000		0
00	010					220A123 163	0011502016						
0005		23	01	25	1.00		DISASSEMBLE WHEEL SM		.150	.040	.201		42
00	010.	Ε		RWB-DW-1	1.00	DIS SM WHL (TIE FOLT TYPE)			.0980	5	.122		
00	020	=		RWB-DW-T	5.00	REM UNCESTR WHL TIE BOLT	10 TIE BOLTS		.01056		.066		
0;	:10	Ε		RJP <del>-PW-R</del>	1.00	REM RPL PAPRWAK SIGN OFF D	<b>0</b> Σ		.0100	i	.012		
2006		-3	01	25	1.00		REMOVE BEARING CUPS		.226	.057	.283	.3 :	58
00	010	Ξ		5WB-50-0	1.00	REMOVE BEARING CUPS			.16346	,	.204		
90	020	Ε		RWE-MH-0	.50	LOAD HOOK W/WHEELS F/CLENI	NG		.1053	2	.065		
00	000	Ε		RJP-PW-R	1.00	REM RPL PAPRWRK SIGN OFF D	OC		.01001		.012		
700 <b>0</b>		ΗВ	01	25	.01		LABOR STD HISTORY		.000	.000	.000		0
00	010					07DEC84 2 YEAR REVIEW/UPSRI	ADE TO ENG STD						-
90	011					<old std=""> .25</old>							
QC	020					06JUNSS CHANGED SKL CODE N	D TM CHN6						
00	)30					26JUNES ADDED NICK&BURR TM	(TM WAS .20 )						
05	700					D. FARKER TECHN MANEAA							

D INTERROGATE LABOR STANDARDS. INPUT



'NESW152676	SWC001					•		
W LWIGEOT		LABOR STANDARD	OPERATION RESOURCE	STANDARD	AND METHOD	ANALYSIS	11/02/88	A-E0469-MM1-DY-M4
16	5257A	F4 N WHL 220A123		RCC	MAPGW		443-7-1143	81279
10.00 75.05	100	WIT SE A/D SEU						

001				. =	ACCOUNTS DESCRIBED CARNES	OR AND METTION ANALYSIS	11/00/00		/ P. WU.	DV MAE	2455	0004
7 <b>A</b>											THUE	0001
3	Ä	F	A/R REV									
K	#R	A FA	SUPPORT	330	< DE	SCRIPTION	>	PASE				
L	K	00	ELEMENT	FACT	STORED	SUPPLEMENTAL		FOURS	TIME	HOURS	DLY	PST 5
к:	ΞA	5	J 99701	1.00	PERCENT ENGR 46.7	CLEAN F4 NOSE WHEEL		.54		.54		
11	.54	00		ሰባ		PART NEMPER/NON		.000	.000	.000		0
					220A123 16	30011532016						
ΚĪ	01	27		1.00		CHEM CLEAN WHEEL ALU	M	.116	.031	.147	2.8	27
		Z	LG-CL-MI	.50	LOAD & UNLOAD CARRIER CLE	AN		.2:200	1	.134		
		R	JP-PW-R1	1.00	REM RAL PAFRWAK SIGN OFF	CGC		.01001		.012		
ΚĪ	01	27		1.00		BLAST CLEAN WHEEL SM		.152	.041	. 194		3 <b>6</b>
		5	WB-03-B1	1.00	BLAST SM PT OR BSKT V/SM	PTS		.03668		.046		
		7	1 S-01 -M1	50	I HAD & LINE HAD CARRIER CLE	AN		.21200	1	.134		
		ā	ur-rw-ñi	1.00	REM APL PAPRWRK SIGN OFF	COC		.01001		.012		
ΚĬ	01	27		.14		BLAST CLEAN WHEEL SH		.152	.006	.027		5
		5	WS-CB-81	1.00	BLAST SM PT OR BSKT V/SM	PTS		.03668	ļ	.046		
		2	LG-CL-M1	.50	LCAD & UNLOAD CARRIER CLE	AN		.21200	)	.134		
		3	GP-PW-R1	1.00	REM RPL PAPRWAK SIGN OFF	DOC						
ΚĪ	01	27	,	1.00		ANODIZE STRIP WHEEL	ALUM	. 136	.037	.173	.7	32
		Z	CD-ST-S1	1.00		ANODIZE STRIP		.12630	)	.160		
		2	MP-PW-R1	- 1 00	REM RPL PAPRWRK SIGN GEF	CUC		.01001		.012		
ķŢ	01	27	,	.01		LABOR STD HISTORY		.000	.000	.000		0
					2 YEAR REVIEW/NO TIME CHA	NGE						
					18JULSS MOVED NAB TO HB S	KL (TH WAS .29)						
					D. PARKER TECHN MANEAA							
	7A S K L KI KI KI KI KI	7A F S W K #R L K KI EA KI 01 KI 01 KI 01	KI 01 27  KI 01 27  KI 01 27  KI 01 27	LABOR STA  7A F4 N WHL 220A  S W F FF A/R REV  K #R A FA SUPPORT  L K C DC ELEMENT  KI EA S J 98301  KI 01 00  KI 01 27  ZLG-CL-M1  RUP-FW-R1  KI 01 27  RWB-C8-B1  7LG-CL-M1  RUF-FW-R1  KI 01 27  RWB-C8-B1  ZLG-CL-M1  RUF-FW-R1  KI 01 27  ZCD-ST-S1  RUP-PW-R1  KI 01 27  ZCD-ST-S1  RUP-PW-R1	LABOR STANDARD  7A F4 N WHL 220A123  S W F FF A/R REV  K WR A FA SUPPORT OCC  L K C DC ELEMENT FACT  KI EA S J 99T01 1.00  XI 01 00 .00  KI 01 27 1.00  RJP-FW-R1 1.00  RUB-CB-B1 1.00  7LG-CL-M1 .50  RUF-FW-R1 1.00  KI 01 27 1.4  RWB-CB-B1 1.00  ZLG-CL-M1 .50  RUF-FW-R1 1.00  KI 01 27 1.4  RWB-CB-B1 1.00  RJP-FW-R1 1.00  KI 01 27 1.00  RJP-FW-R1 1.00  RJP-FW-R1 1.00  RJP-FW-R1 1.00  RJP-FW-R1 1.00  RJP-FW-R1 1.00	LABOR STANDARD OPERATION RESOURCE STANDAM 7A F4 N WHL 220A123 RI S W F FF A/R REV K WR A FA SUPPORT DCC (	LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  7A F4 N WHL 2004123 RCC MMPGW  S W F FF A/R REV  K WR A FA SUPPORT CCC <	LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/02/38 7A F4 N WHL 2004123 RCC MNPGW GW3-7-114 S W F FF A/R REV K WR A FA SUPPORT OCC (	LABOR STANDARD   OPERATION RESOURCE STANDARD AND METHOD ANALYSIS   11/02/88   A-E04   F4 N WHL 2004123   RCC MMFSW   GM3-7-1143   A-E04   F4 N WHL 2004123   RCC MMFSW   GM3-7-1143   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04   A-E04	LAECR STANDARD   OPERATION RESOURCE STANDARD AND METHOD ANALYSIS   11/02/88   A-E0465-MM;	LABOR STANDARD   OPERATION RESQUECE STANDARD AND METHOD ANALYSIS   11/02/88   A=0465-MM1-DY-M45   RCC MM-PGW   443-7-1143   81279	LABOR STANDARD   OPERATION RESOURCE STANDARD AND METHOD ANALYSIS   11/02/88   A-E046E-MM1-DY-M45   FAGE   FACT   NWHL 2004123   RCC MMPGW   443-7-1143   E1279

ROC PRD NROP NR <---×--> 1234567890123456 ELSE PUT IN END

	15	267	²A	1	- 4	L N	ABOR STA WHL 2204	NDARD 1123	OPERATI	UN RES	SOURCE	STANDARD RCC	ANI MNP	HETHOD Na	ANALYSI	S 02/01/39 4W3-7-114	A-E0	46B-HM1 8	L-DY-H45	PAGE	0001
FER	TECH						A/R REV														
	STEP															'AL	BASE	PFD			A
																nL	HOURS	TIME	HOURS	IILY 	FCT C
GRENA	S	X	DB	ΕA	2		J 98301	1.00	PERCENT	ENGR	99 <b>.9</b>		NDI	F4 NOSE	WHEEL		.12		.12		
001	-												NDI	TIE BOI	JS IST	TIME	1.005	.014	.145		117
									MAGNAGL								.09138	3	1.115		
													MII	DRIVE	EYS 1ST	TIME	.822	,012	.119		95
									MAGNAGL(								.09138	3	.912		
			D8	01		00									R/NSN		.000	.000	.000		0
	0010											1630									
	0020								220 <b>A2B3</b>			1530	0115	32016							
2001	l																.099	.011	.110	•7	89
	0010	Ε				Zι	_G-ND-Z1	2.00	ZYGLO IN	ISP SM	IALL PA	RT BLD50	,				.04468	<b>b</b>	.099		
	0020	Ε				8.	JP-P¥-R1	1.00	REM RPL	PAFRW	RK SIG	IN OFF DO	3				.01001	l	.011		
	) 0900		DB	01								NEL-1 7			HISTORY		.000	•000	.000		0

RCC PRD NROP NR (--->(--->) 1234567890123456 ELSE PUT IN END

## .PSW16257AWE150

16 ERTROH	267A		LASCR STAN 14 N WHL 220A1 F PF A/R SEV		REC MNPSW 11/02/9			DY-M45 91279	PAGE 0001
		#R	A FA SUPPORT C DC ELEMENT		<pre>STORED DESCRIPTION&gt; SUPPLEMENTAL</pre>		PFD TIME	STD HOURS	A DLY PCT C
0001 0010	-	EA 01		.00	PERCENT ENGR 17.5 E&I F4 NOSE WHEEL D/B PART NUMBER/NSN 220A2B3 1630011532016	.35 .000	.000	.35 .000	0
	DI E N		RLG-RS-NC	1.00 1.00 1.00	NICK & BURR WHEEL SM/HALF NICK & BURR PTS-CONST F/PREP	.02312 .09187		.159 .029 .116	45
0030 0010 0020 0030	D ! N E	01	15 5WB-OH-W2	1.00 1.00 1.00	E & I AND ROUTE WHEEL E&I AND ROUTE WHEEL HALF REMV WHL HLF F/PAINT CONVYOR REM RPL PAPRWRK SIGN OFF DOC	.14919 .00833	.025	.012 .193 .171 .009	55
7000 0010 0900	ùî			.01	CASCR STANDARD HISTORY  O7DEC84 2 YEAR REVIEW/ND TIME CHANGE N MCNRCE/MANEAA	.01001 .000		.000	0

O INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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16267A F4 N WHL 220A123	D GERATION RESCURCE STANDARD AND METHOD ANALYSIS 11/02/68 ROC MAPSW 4W3-7-114		M1-DY-M45 91279	PAGE COCI
	CC <> STORED DESCRIPTION> Supplemental			A DLY PCT C
0001 21 01 00 .6	00 PERCENT ENGR 17.5 ENI F4 NOSE WHEEL I/B 00 PART NUMBER/NSN 2004282 1630011611591	.35	.35	0
0019 01 01 27 1.0	NICK & BURR PIS-CONST FYPREP	.125 .034 .02312 .09187	.029	45
0030 E RJP-PW-R1 1.0 0030 DI 01 15 1.0 0010 N 1.0	OO REM RPL PAPRWRK SIGN OFF DOC DO E & I AND ROUTE WHEEL	.01001	.012	55
	00 REMV WHL HUF F/PAINT CONVYGR 00 REM RPL PAPPWRK SIGN OFF DOC 01 LAECR STANDARD HISTORY 07DEC84 2 YEAR REVIEW/NG TIME CHANGE	.00833 .01001 .000 .000	.009 .011 .000	0
0700	N MONROE/MANEAA			

RCC PRD NROP NR '---X--->

1214567890123456 ELRE FUT IN END

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E3					LABOR STAI HEEL F4 NOSE F PF A/R REV		GPERATION RESOURCE	STANDARD RCC	AND MET MNPRA	HOD ANALYSIS	11/02/98 4W3-7-114	A-E0 3	468-MM!	1-0Y-M45 31279	PAGE	0001
3		T	L 1	.0	A CA CUMPOST	000	<	DESCR	RIPTION		<del></del> >	FASE	PFD	STD		A
	-5:EP	IJ	L 	K 	U DU ELEMENI	FACT	STORED			SUPPLEMENTAL		HCURS	TIME	HOURS	DLY	PCT C
:55	S	Ε	JA E	A	: J 88301	1.00	PERCENT ENGR 95.5 220A292		MACH WH	L HALF SUBASSY	/ F4N I.	1.07		1.07		
0000	1		JA 0	1	00	.00			PART NU	MEER/NSN		.000	.000	.000		0
	0010						220A292	16300	1161159	1						
0010	0		JA 0	1	15	.50	S/U VERT MILL BORE HOIST HANDLE NO WAR ALIGN VERTICAL AXIS		REM BEA	RING BORE BUSH	I.MED.	.787	.057	.453		42
	0010	Ξ			RML-SU-V2	. 25	S/U VERT MILL BORE	LAG FIXTE	FRORATE	CVER 8 PARTS		.3015	7	.230		
	0020	Ε			FML-HP-00	1.00	HOIST HANDLE NO WAR	∖P 2 CLAMP		JIG BORE		.1577	5	.181		
	0030	Ε			RML-AL-AB	1.00	ALIGN VERTICAL AXIS ALIGN HOLE TO SPINI BORE HOLE 2 X 2 GRO	ROD				.1269	9	.146		
	0040	Ξ			RML-AL-AC	1.00	ALISM HOLE TO SPINE	LE ROD				.0760	9	.087		
	0050	Ξ			RML-BA-CD	1.00	BORE HOLE 2 X 2 6AC	UP 1	USE PRO	PER ELEMENT/TA	RLE	.2162	6	. 248		
	0060	Ε			RJF-FW-Ri	1.00	REM RPL PAPRWAK STO	IN OFF DOC				.0100	1	.011		
0045	5		JA 0	•	15	. 25	REM RPL PAPRWAK SIG		EEARING	BORE REP.PENS	OTTI	.508	.019	146		14
	0010	N				1.00			SET UP	PENSOTTI		.1670	0	.192		-
	0020	Ε				1.00	4	.26	MACHINE	SEARING BORE		. 2933	3	.337		
	0030	Ξ			rup-pw-ri	1.00	REM RAL PAPRWAK SIS	N OFF DOC	/			.0100	1	.011		
	0040	Ε			FPL-MH-P1	1.00	GET PALLET JACK & M	OVE PARTS	i			.03815	5	.043		
0050	)		JA O	1	15	.05	REM RPL PAPRWRK SIG GET PALLET JACK & M S/U TO O/S BOSSES R PART DN/OFF MACH HA SPOT-FACE OR COUNTE REM RPL PAPRWRK SIG SET UP TO REBUSH SO INSTALL ONE STRAIGH REM RPL PAPRWRK SIG SET UP SMALL MEDIUM		SPOT FAC	E TIE BOLT HO	LES	.524	.005	. 036		3
	0010	Ε			RDR-SU-R1	1.00	S/U TO D/S BOSSES R	AD DRILL	•			.56379	3	.648		•
	0020	Ε			RML-HP-H1	1.00	PART ON/OFF MACH HA	ND NO RAP	•			.03068	3	.035		
	0020	Ε			KAL-SM-31	1.00	SPOT-FACE OR COUNTE	RBORE	•			.02004	- }	.023		
	0040	Ξ			RJP-EW-R1	1.00	REM RPL PAPRWRK SIG	N OFF DOC				.01001	1	.011		
0075	5		JA O	:	15	1.00			INST CUF	INTO BUSHING		.077	.012	.089		8
	0010	Ē			REW-BU-S1	. 25	SET UP TO REPUSH BO	SSES	PRCRATE	CVER 4 FARTS		.18669	)	.053		_
	.20	Ξ			RBW-BU-44	1.00	INSTALL ONE STRAIGH	T BUSHING				.02062	2	.023		
	2:30	Ξ			RJP-FW-R1	1.00	SEM SPL PAFFWRK SIG	N GEF DOC				.01001		.011		
0030	)		JA 0:	1	15	1.00		1	MACH BEA	RING BORE BUS	HING	.229	.034	. 264		25
	0010	Ε			RLA-SU-S3	.25	SET UP SMALL MEDIUM 1ST PART IN-CUT SCR DIA 4.00-5.00 REM . REM RPL PARRWRK SIG	LATHE	PRORATE	OVER 8 PARTS		.49962	2	.143		
	0020	Ξ			RLA-HP-C:	1.00	1ST PART IN-OUT SCR	OLL CHUCK				.01006	- I	.011		
	0030	Ξ			KML-TA-HC	1.00	DIA 4.00-5.00 REM .	033250				.03497	•	.097		
	0040	Ε			RJP-PW-R1	1.00	REM RPL PAPRWAK SIG	N OFF DOC				.01001		.011		
0082			ia o:		15	1.00		•	NST SFA	aing agas aigi	a & CUD	∆ <b>7</b> 7	017	Voa		3
	0010	Ε			REW-BU-S1	. 25	ACT 115 TA BESTON SA									-
	0020	ε			REW-EU-A4	1.00	INSTALL CHE STRAIGH	T BUSHING		_		.02062		.023		
1	0030	Ε			RJP-FW-R1	1.00	REM RPL PAPRWRK SIG	N OFF DOC				.01001		.011		
9000		·	IA 01	!	15	1.00	SE: UP TO REBUSH BU INSTALL ONE STRAIGH REM RPL PAPRWRK SIG C. W. RIGBY MAMEL-	1	ABOR ST	ANDARD HISTORY	1	.000	.000	.000		٥
(	0900						C. W. RIGBY MANEL-	i 73357	1			• •				•

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£ .1/41020/1304100			
	LAPER STANDARD	- OPERATION RESOURCE STANDARD AND METHOD ANALYS	SIS 11/02/98 A-

ALL HAM	010/HD	04100	'										
	• , -	14.7A	4.		GRACINATE:	OPERATION RESOURCE	STANDARD AND	METHOD ANALYSIS	11/02/58	B A-E0 •*	463-MM1	L-DY-M45	PAGE 0001
				RHEEL F4 1 F FF A/R	1005		NUC TIME	TAME .	483-7-11	•↓	5	3:2/7	
	. IUd	ש ב	A.	6 65 A/A	757 7007 000	• /	necostet	TON	\	EACE	פרת	C * 75	٨
		7.5	#K	H 14 501	יייי דיייי	. רדייייי	05304161	CURRENTAL	,	CHOCIDE	TTME	3:3	H N SET D
	75 E	J L	K.	t dt eie:	ENI FALI	STORED		SUPPLEMENTAL		700A5	1:ME	 	ULY PU. U
2150						PERCENT ENGR 96.7	MAC	H WHL HALF SUBASS	Y EAN	1.50		1.50	
0000	1	JA	01	00	.00	•	PAS	T NUMBER/NSN		.000	.000	.000	Ò
• • • •	0010		•			220A2B3	16300115	T NUMBER/NSN 32016				,,,,	
6010	3	JA	01	15	.50	)	REM	BEARING BORE BUS	H.MED.	.797	.059	.450	70
	0010	Ξ		EML-Si	j-y2 .25	S/U VERT MILL FORE	LRS FIXTRPRO	RATE OVER 8 PARTS	,	.3016	7	.270	
	0000	Ξ		5ML1	-CC 1.00	HOIST HANDLE NO WR	AP 2 CLAMP	JIG FORE					
	0050	Ε		RML-AL	-AB 1.00	ALIGN VERTICAL AXI	S ROD			.1259			
	0040	Ε		FML-4	<b>40</b> 1.00	ALIGN VERTICAL AXI ALISN HOLE TO SPIN	DLE ROD			.07509	9	.087	
	0050	Ε		RML-BA	A-CD 1.00	BORE HOLE 2 X 2 GR	OUP 1 USE	PROPER ELEMENT/TO	ABLE	.2152	5	.248	
	0040	_		5 15_6(	I-E1 1 00	DEM DOL DARREDY C*	SM OFF DOC			0100	1	011	
004	5	JA	01	15	.25		BEA	RING BORE REP.PEM	SOTTI	.508	.019	.146	10
	0010	N			1.00	•	SET	UP PENSOTTI		.16700	)	.192	
	0020	Ξ			1.00	4	.26 MAC	HINE BEARING BORE		.2933	3	.337	
	0030	Ε		RJP-FI	⊢R1 1.00	REM RPL PAPRWAK SI	GN OFF DOC/			.0100	1	.011	
	0040	Ε		RFL-M	i-P1 1.00	GET PALLET JACK &	MOVE PARTS/			.0381	5	.043	
00.56	Λ		01	15	() <b>-</b>		451	I FACE TIE BULL HI	[] FS	. 5.74	.005	.035	2
	0010	Ε		RDR-S	J-R1 1.00	S/U TO O/S BOSSES PART ON/OFF MACH H SPOT-FACE OR COUNT REM RPL PAFRNRK SI	RAD DRILL ,			.5637	3	.648	
	0020	Ε		RML-H	-H1 1.00	PART ON/OFF HACH H	AND NO RAP,			.03066	3	.035	
	0030	Ε		KAL-SI	<del>-31 1.00</del>	SPOT-FACE OR COUNT	ERBORE ,			.02004	4	.023	
	0040	Ε		835-54	⊢R1 1.00	REM RPL PAFRWRK SI	SN OFF DOC,			.01001	I	.011	
0960	0	JA	01	15	.80	)	VAL	VE STEM HOLE REP I	RAD DR	. 459	.055	. 423	28
	0010	E		RDR-St	⊩R1 .25	S/U TO G/S BOSSES C/S BOSS W/STEP RM DEBUR HOLE/CUTGUT REM RPL PAPRIMRK SI SET UP TO REBUSH B INSTALL CNE STRAIG	RAD DRILL PRO	RATE OVER 8 PARTS		.56378	3	.162	
	າງ20	Ε		RDR-B0	-A1 1.00	C/S BOSS W/STEP RM	R RAD DRL			.3045	3	.350	
	7020	Ε		REW-DE	3-A1 1.00	DEBUR HOLE/CUTOUT	BOTH SIDES			.00423	3	.004	
	0040	Ε		rjp-pv	HR1 1.00	REM RPL PAPRWAK SI	EN OFF DOC			.01001	l	.011	
w7.	<u>.</u>	JA	01	15	1.00		ING	T CUP INTO BUSHING	2	. 0.77	012	.089	6
	0010	Ε		R∃₩-Bl	J-S1 .25	SET UP TO REBUSH B	esses pro	RATE OVER 4 PARTS		.18669	7	.0ಮ	
	0020	Ε		rbw-bl	J-44 1.00	INSTALL ONE STRAIG REM RPL PAPRWRK SI	HT BUSHING			.02061	2	.023	
	0030	Ε		RJP-PV	HR1 1.00	REM RPL PAPRWRK SI	GN OFF DOC			.01001		.011	_
0080	)	JA	01	15	1.00		MAC	H BEARING BORE BUS	SHING	.229	.034	.264	18
						SET UP SMALL MEDIU		RATE OVER 8 PARTS					
	0020					1ST PART IN-GUT SC				. 01004		01.	
	0030					DIA 4.00-5.00 REM				.08497		.097	
	0040					REM RPL PAPRWRK SI			<b>.</b>	.01001		.011	
	5		01	15	1.00			T BEARING BORE BUS		.077		.089	6
	0010					SET UP TO REBUSH 3		RATE OVER 8 PARTS		. 19669		.053	
	0020					INSTALL ONE STRAIG				.02062		.023	
	0030					REM RPL PAPRWRK SI			214	.01001		.011	^
9000	)	JA	01	15	1.00		LABI	OR STANDARD HISTOR	₹7	.000	.000	.000	0

C. W. RIGBY MANEL-1 73357

TO INTERROGATE LABOR STANDARDS, INPUT

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A	CTS/UNGIFO	

	F4 N WHL 220A1		STANDARD AND METHED ANALYSIS 11/00/ REC MNFRC 4W3-7-1			PAGE 0001
			DESCRIPTION SUPPLEMENTAL			A BLY FOT C
	EA B	. 00.	FAN WHEEL HALF SUBASSY C/B FART MUMBER/NEN 1830011532016	.19 .000 .00		•)
0070 UP 0010 E 0000 E	ZFL-AN-B1		ANCOITE SMALL FART VEASKET	.156 .03 -90782. .25892 .001001	.107 .075	
9000 EP 0010 0011 0900		.01 DOJUMBS REWROTE STE DOME ON OFERATION )	LASER STND HISTERY D TO MATCH 958 WORK FREVIOUSLY XNESC (OLD STND WAS .225) MANEL TECHN 77357	.000 .00	000.	ŷ

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	N #40 2204120		METHED ANALYSIS 11/02/88 RC 4WJ-7-114				FASE 3001
	FA FIRHCRT 000 (		SUPPLEMENTAL				A GLY PCT 8
		VT ENGR 99.9 F4 3	NOSE WHEEL HALF SUBASSY :	.:9		.:9	
3001 LP 01 XC10		F4R   16100115		.300	.000	. Жө	ŷ
W79 UP 91			DIZE SMALL FART	. :55	.037	.:97	.8 100
	FW8-07-01 1.00 VAFOR			.09709	7	.:37	
₩20 <b>£</b>	251-49-3: 1.00 AVGD10	E SMALL FART		. 05392	2	.073	
0000 E	RUP-PW-F1 1.00 REM RE	L PAPRWRK SIGN OFF DOC		.01601	l	.012	
3000 JF 31	24 .01	LAEC	R STND HISTORY	.000	.000	, (w) ₍ ()	0
3010	oculns	86 REWROTE STD TO MATCH 958	WORK PREVIOUSLY				
0011	DONE 3	N OPERATION XNERO (OLD STA	D WAS .225)				
0900		KERRY COOP MANEL TECHN 70	257				

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TMNFGP1	16.	16267A			F4 .		N WHL 220A123 PF A/R REV		OPERATION RESOURCE	STANDARD RCC	AND METHOD ANALYSIS MAPER	04/26/89 4W3-7-114	A-E04 3	6B- <b>MM</b> 1 8	I-DY-H45 11279	PAGE	0001
									<b>(</b>	DESC.	RIPTION	)	BASE	PFD	STD		A
											SUPPLEMENTAL			TIME	HOURS	DLY	PCT C
PS150	S	 E	YΗ	ΕA	5		] 88301	1.00	PERCENT ENGR 99.9		PREASSY F4 NOSE WHEE	L 0/B	. 28		.29		
000	1		үн	01		00		.00			PART NUMBER/NSN		.000	.000	.000		0
	00:0								220A283	1630	PREASSY F4 NOSE MHEE PART NUMBER/NSN 011532016 - PREINSPECTION WHEE!						
009	0		γH	01		21		1.00			PREINSPECTION WHEEL	HALF	.015	.003	.019		7
	0010	Ε				R	WB-JP-W2	2 1.00	PREP TO ASSY OR DI	SSY WHEEL			.00442	)	.005		
	0020	E				ĸ	AL-60-40	1.00	INSPECT VISUAL				.00115	j	.001		
											C		.01001				
009	25		ΥH	0.2		21		1.00			RACE INSTALLATION WH	IL/HALF	.178	. 037			76
	0010	ξ (				R	ив-вс-01	1.00	INSTALL BEARING CL	<b>P</b> S			.16838		. 203		
	0020	Ε				R	JP-PN-R	1 1.00	REM RPL PAPRHRK SI	GN OFF DO	C		.01001		.012		
011	5		ΥH	01		21		1.00			INSTALL SEALS & RETA	INERS	.041	.009			18
	0010	E				£	HB-AN-B	1 1.00	INSTL BEARNG/SNAP	RNG SECUR	D		. 02459	)	.029		
	0020	E				R	MB-AM-C.	1 1.00	INSTL TIRE CHANGE	DATA PLAT	Ε		.00692				
	0030	E				R	JP-PH-R	1 1.00	REM RPL PAPRHRK SI	GN OFF DO	C		.01001		.012		
900	00		YΗ	01		21		.01			LABOR STANDARD HISTO	RY	.000	.000	.000		0
	0010	)									LOAD LINE(OLD STD) .	70					
	0020	)							25SEP84 ADD STEPS	0007 & 00	08 SUB 0P 0010						
	0021	!							(OLD STANDARD).78								
	0030	)							10DEC84 2 REAR REV								
	0031	1							7MAR86 CHANGED SKI	ILL CODE F	ROM YG TO YH						
	0032	?							NO TIME CHANGE KERRY COOP								
.=.	0900	)							KERRY COOP	MANEAA TE	CHN 73357						

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											RC	LINE-PA		4#3-/-114.	3	ð	12/9		
<b>D</b> JB		7	K	#R	A	FA		occ								PFD			A
	STEI	סי	L	K	С	DC	ELEMENT	FACT		STOR	ED		SUPPLEMENTAL		HOURS	TIME	HOURS	DLY	PCT C
PS155	S	Ε	YH	ΕA	5		J 8830	1.00	PERCENT	ENGR 99	.9	PREASSY	F4 NOSE WHEE	L 1/B	.28		. 28		
000	1		ΥH	01		00		.00				PART NUM	BER/NSN		.000	.000	.000		0
	001	)							220A282		163	001161159							
								1.30				PREINSPE	CTION WHEEL	HALF	.015	.003	.019		7
											DISSY WHEE				.00442		.005		
									INSPECT						.00115	5	.001		
											SIGN OFF D	OC			.01001	!	.012		
009	75												STALLATION WH	IL/HALF	.178	.037	.216		76
						RS	/B-BC-0	3 1.00	INSTALL	BEARING	CUPS				. 16838	3	. 203		
								1 1.00	REM RPL	PAPRIER	SIGN OFF D	oc				1	.012		
	5							1.00				INSTALL	SEALS & RETA	INERS	.041	.009			18
	001	0 E				RI	NB-AN-B	1 1.00	INSTL B	EARNG/SN	iap ang secu	RD			.0245	7	.029		
											IGE DATA PLA				.00692	2	.008		
	003	0 E				R.	JP-PH-R	1 1.00	REM RPL	PAPRIIRK	SIGN OFF D	oc				1	.012		
900	00		YH	01		21		.01				LABOR ST	TANDARD HISTO	RY	.000	.000	.000		0
	001	0							06JUN84	add <b>S</b> ue	OP 0001 4U	NLOAD LINE	EKOLD STD) .	70					
	002	0							255EP84	ADD STE	PS 0007 & 0	008 SUB <i>D</i> F	0010						
	002	1							COLD ST	ANDARD).	78								
	003	0							10DEC84	2 REAR	REVIEW/NO T	INE CHANGE	E						
	003	1							7MAR86	CHANGED	SKILL CODE	FROM YG TU	) YH						
	003	2							NO TIME	Chang <b>e</b>									
	090	0								KERRY C	10P MANEAA 1	ECHN 73357	7						

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3216	16762c		F	LABOR STAN 4 N WHL 220A1		OPERATION RESOURCE ST	ANDARD AND METH RCC MNPGP	DD ANALYSIS	11/02/98 4W3-7-114	8 A-E04 43	463-MM1 8	-0Y-M45 1279	FAGE 0001
3	TH.	S S T K	₩ #R	F PF A/R REV	000	<	- DESCRIPTION -	SUPPLEMENTAL	·>	EASE HOURS	PFD TIME		A DLY PCT C
0001	S	YΗ	01	00	.00	FERCENT ENGR 94.5	PART NUM	BER/NSN	EL	.13			0
	• 00⊹∂	•••	••			220A123	1630008521432						
0010	)	YH	01	21	1.00		WHEEL MA	TCH UP			.023		100
	0010					GET EASY AND PLACE EX				.0009		.001	
	0020	Ξ		FWB-UP-P7	1.00	UNEK PARTS-BK KEY-SNA	AP RING				7		
	0030				1.00		MATCH WH	EEL HALFS 2	HALFS		0		
	0040	Ξ		RUP-FW-R1	1.00	REM RPL PAPRWRK SIGN	OFF 000				1		
	)						LABOR ST	ANDARD HISTO	)RY	.000	.000	.000	0
133	0010		•			06JUNB4 ADD SUB OP 00	XX1 &UNLOAD LINE	⟨CLD STD⟩ .	.70				
	0020					25SEP84 ADD STEPS 000							
	0021					(OLD STANDARD).78							
	0030					100EC84 2 REAR REVIEW	I/NO TIME CHANGE						
	0031					7MAR86 CHANGED SKILL							
	0032					NO TIME CHANGE							
	0900						NEAA TECHN 73357	,					

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	LABOR STANDARD N WHL 220A123 PF A/R REV	CPERATION RESOURCE STAF	NDARD AND METHOD ANALYSIS 11/ RCC MNPGP 4W3-	02/98 A-E04 7-1143		0Y-M45 11279	PAGE 0001
S TK #RA			DESCRIPTION		PFD TIME	STD HOURS	A DLY PCT C
10 S E YH EA S	J 38301 1.00		ASSY F4 NOSE WHEEL FART NUMBER/NSN	.05	.000	.05 .000	0
0010	•••		1630008521432	.000	. 500	.000	v
CO15 YH 01	21 1.00	)	FINAL WHL ASSEMBLY SM/NCE	RK .049	.010	.059	100
0010 E	RWB-AW-T1 4.00	INSTL UNGESTRUCTED TIE	BOLT	.00975		.047	
∂020 E	RJP-FW-R1 1.00	REM RPL PAPRWRK SIGN OF	FF 90C	.01001		.012	
9000 YH 01	21 .01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010		06JUN84 ADD SUB CP 0001	L %UNLOAD LINEKOLD STD) .70				
0020		255EP84 ADD STEPS 0007	\$ 0008 SUB GP 0010				
0021		(OLD STANDARD).78					
0030		10DEC84 2 REAR REVIEW/N	#D TIME CHANGE				
0031		7MAR86 CHANGED SKILL CO	DDE FROM YG TO YH				
0032		NO TIME CHANGE					
0900		KERRY COOP MANEA	NA TECHN 73357				

INTERROGATE LABOR STANDARDS. INPUT

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					N	WHL 220	9123				AND METHOD ANALYSIS MNPGP				PAGE	0001
		T	K :	ir i	FA		7 000				SUPPLEMENTAL		PFD TIME		DLY	A PCT C
000	1		35 (	01	00		.00				PAINT F4 NOSE WHEEL FART NUMBER/NSN			.33 .000		0
0110	0010	w w w w	JS (	)1	25 6 8 8 8	PL-PA-) IS-SF-M WB-OH-W WB-SC-01 WB-SC-P1	1.00 1 4.00 1 1.00 1 1.00 2 1.00 3 1.00	INST MEN' MASK & UI HANG MAL PNT MAL ! PNT MAL !	THREADED PL NMASK MEDIL HLF ON PAI HALF-ZINC (	LSTC PLUG UM FART (NT CONVYR CHROMATE COAT)	FAINT WHEEL POLY 2 COATS	.00093 .01242 .02336 .11574 .10214	; !	.029 .144 .127	4.0	100
9000	0010 0020 0021 0030 0900							06JU <b>N84</b> F	REMOVE UNLO ADD STEPS ( (GLD STD) . 2 YEAR REVI	ADING PAI	LABOR STANDARD HISTON NT LINE (GLD STD) . SUB DP 0010 E CHANGE	.000	.000	.000		0

3 INTERROGATE LABOR STANDARDS, INPUT

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## 3P16267APP155

			LABGR N WHL F FF A/R	220A123	CPERATIC!	N RESOURCE	STANDARD RCC	AND METHOD ANALYSIS MNPGP	11/02/88 4W3-7-114	A-E0 3	46B-MM1 8	1-DY-H45 21279	FAGE	0001
Si	T K	#R #	A FA SUF	FORT GC	C <	070003	DESC	MIPTION	<del></del> >	BASE	PFD			A
	EPDL	κι 	. DU ELE	MEN) FAL				SUPPLEMENTAL			TIME	HOURS	DLY	PCT C
55	S E IS	EA 5	J 80	8301 1.04				PAINT F4 NOSE WHEEL				.ಪ		
0001	₫S	01	00	.0				PART NUMBER/NSN		.000	.000	.000		0
00	10				220A282		16300	1161159						
0100	<b>3</b> \$	01	25	1.00	)			PAINT WHEEL		.267	.067	.304	4.0	100
00										.0009	3	.004		
900	20 E		913-9	P-M1 1.00	MASK & U	WMASK MEDI	UM PART			.0124	2	.015		
00	30 E		RWB-01	H <del>-W</del> 1 1.00	HANG WHL	HLF ON PA	INT CONVYP	-		.0233	6	.029		
00	40 E		RWB-S0							.1157	4	.144		
00	50 E		RWB-St	C <del>-P</del> 3 1.00	PNT WHL F	HALF (2ND (	COAT)	POLY 2 COATS		.1021	4	.127		
000	60 E		RJP-PI	W-R1 1.00	REM RPL 9	AFRWAK SI	ON OFF DOO	•		.0100	1	.012		
9000	3S	01	25	.0:	1			LABOR STANDARD HISTOI	RY	.000	.000	.000		0
00					06JUN84 F	REMOVE UNLI	DADING PAI	NT LINE (OLD STD) .:	57					
00:	20				25SEP84 A	DD STEPS	0005 & 000	6 SUB GP 00:0						
000	21				<	(OLD STD)	.55							
600	0.0				10DEC84 2	YEAR REV	IEW/NO TIM	6 SUB GP 00:0 E CHANGE						
099	Ю				N MONROE	MANEAA								

INTERROGATE LABOR STANDARDS, INPUT

CO FRO NROP NR

14 (123456) ELSE PUT IN END

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5215287AF7138		LABOR STANDAR		FESGURCE STANDAR	D AND METHOD ANALYSIS C MNPSP	11/02/88 4W3-7-1143	4-E04	68-MM1 8	-DY <del>-M4</del> 5 1279	PAGE 0001
A TECH S S	₩ : #R (	F PF A/R REV A FA SUFPORT ( C DC (SLEMENT) FI		STORED	CRIPTION	·	ease Hours	PFD TIME	STD HOURS	DLY PCT C
56 E N 3 3001 3 0010	S 01	00	.00 220 <b>A</b> 12 <b>3</b>	163	TOUCH UP F4 NOSE WHE PART NUMBER/NSN 50011532016 PAINT TOUCH UP SM &		.41 .000	.010	.41	0 19
0020 E		RWB-FT-02 1 RJP-PW-R1 1	.00 FINAL & T	TUCH UP MED/SML WI PAPRWAK SIGN OFF I	HEL DOC		.05395 .01001	5 !	.067 .012	40
0997 3 0010 N 0020 E			.00		FINAL ACCUMANCE OF FINAL FILL OUT FORM 424 &	ATTACH	.08000	) 5	.100 .065	
0998 3 0010 N 0020 E		1	.00 .00 .00 REM RPL F	PAPRWRK SIGN OFF	FINAL VISUAL INSPECT FINAL VISUAL INSPECT DOC	TION	.12700	) 1	.153 .012	
7000 0010 0010 0020 0021 0030 0900			06JUNB4 F 255EF84 A	REMOVE UNLCADING ADD STEPS 0005 & (CLD STD) .55 2 YEAR REVIEW/NO			.000	.000	.000	0